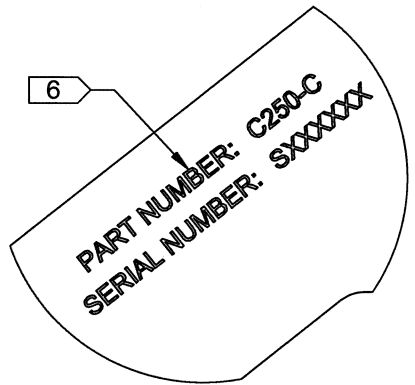
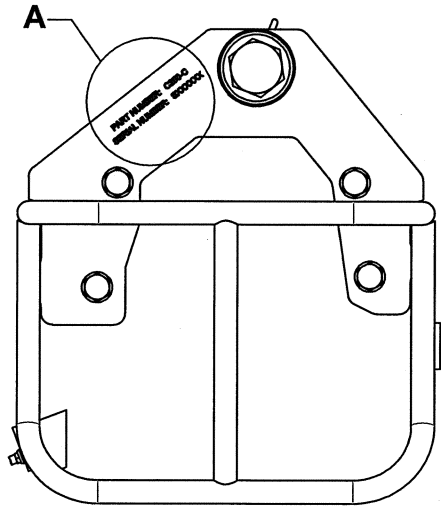
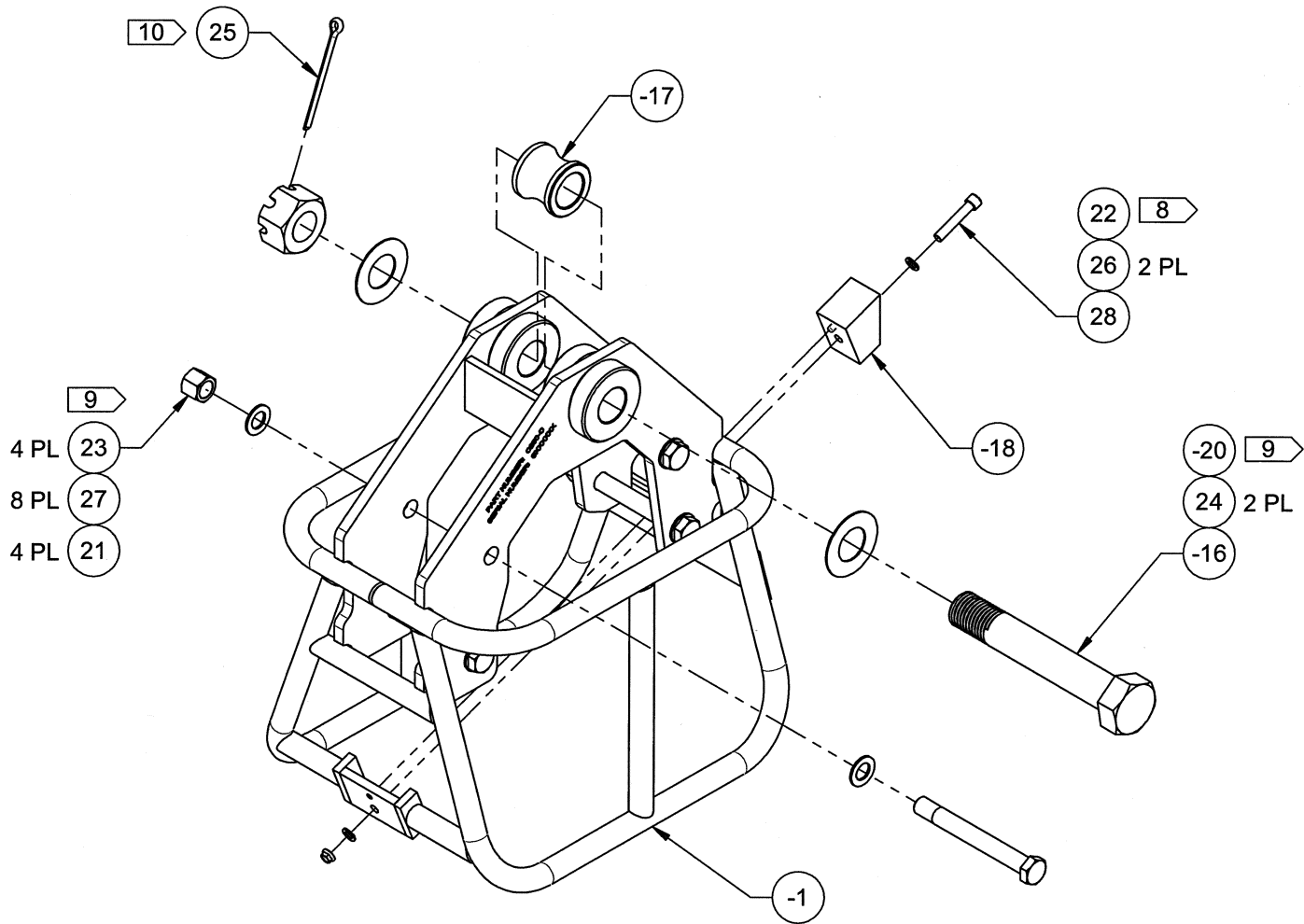


C250-C C250 CAGE ASSEMBLY

| | | | | |
|-----------------------------------|---|---|---------------|-----|
| D | ITEM -20 LIFTING NUT WAS ITEM 27 MS35692-106 | | 19-891 | KPT |
| | -1 FINISH WAS POWDERCOAT RED IS PRIME AND PAINT RED. MOVED T/N AND S/N IDENTIFICATION TO TOP LEVEL ASSEMBLY. DIM WAS 2.190 IS 2.19 REF. DIM WAS 4.10 IS 4.10 REF | | | |
| | -5, -6, -11, -12, -13, -14, -15 REMOVED STOCK VIEW | | | |
| | -16 DIM WAS Ø 1.500 IS Ø 1.500-1.495. DIM WAS 0.867 IS 0.623. DIM WAS 3.50 REF IS 2.06 REF. DIM WAS 5.50-4.67 IS 6.96. DIM WAS 9.00 IS 9.01 | | | |
| | -17 DIM WAS Ø 2.75 IS Ø 2.375. DIM WAS 1.75 IS 1.63. DIM WAS Ø 2.183-2.180 IS Ø 2.173-2.170 | | | |
| C | SEE PREVIOUS REVISION FOR MORE INFORMATION | | 19-821 | KPT |
| | UPDATED DRAWING TEMPLATE | | | |
| | C250-C-1 SUPERCEDES C250-1100 | | | |
| | C250-C-2 SUPERCEDES C250-1100-1 | | | |
| | C250-C-3 SUPERCEDES C250-1100-3 | | | |
| | C250-C-4 SUPERCEDES C250-1100-5 | | | |
| | C250-C-7 SUPERCEDES C250-1100-11 | | | |
| | C250-C-8 SUPERCEDES C250-1100-13 | | | |
| | C250-C-9 SUPERCEDES C250-1100-15 | | | |
| | C250-C-10 SUPERCEDES C250-1100-17 | | | |
| | C250-C-11 SUPERCEDES C250-1100-19 | | | |
| | C250-C-12 SUPERCEDES C250-1100-21 | | | |
| | C250-C-13 SUPERCEDES C250-1100-23 | | | |
| | C250-C-14 SUPERCEDES C250-1100-25 | | | |
| C250-C-15 SUPERCEDES C250-1100-27 | | | | |
| C250-C-16 SUPERCEDES PC250-1120 | | | | |
| C250-C-18 SUPERCEDES PC250-1100-9 | | | | |
| | ITEM 22 AN12-61A WAS PC250-1110 | | | |
| | ITEM 23 MS21042-6 WAS C10-35 | | | |
| | ITEM 24 MS21044N12 WAS PC250-1150 | | | |
| | ITEM 25 MS21299-24 WAS PC250-1130 | | | |
| | ITEM 26 MS24665-690 WAS PC250-1170 | | | |
| | ITEM 27 MS35692-106 WAS PC250-1160 | | | |
| | ITEM 28 NAS1149F0663P WAS C10-36 | | | |
| | ITEM 29 NAS1149F1290P WAS PC250-1140 | | | |
| | REMOVED C250-1100-7 | | | |
| | ADDED C250-C-5, C250-C-6, C250-C-17, C250-C-22, ITEM 30 NAS1351-6-32P, AND ITEM 31 MS16555-646 | | | |
| | -1 REVISED WELDING SYMBOLS | | | |
| | -3 DIM WAS Ø .438 IS Ø 0.397. DIM WAS Ø .250 IS Ø 0.257 | | | |
| | -7 ADDED STEP TO FIT INTO ITEM -9 LIFTING PLATE. DIM WAS Ø 1.520 IS Ø 1.531. DIM WAS 2X .04 X 45° IS 0.04 X 45.0° CMF 3 PL. REMOVED .955 DIM | | | |
| | -8 DIM WAS (2X 71°) IS 71.0° 2 PL. REMOVED 7.90 DIM | | | |
| | -9 DIM WAS Ø 1.520 IS Ø 2.000. DIM WAS Ø .780 IS Ø 0.781. DIM WAS R.06 IS R0.06 4 PL. ADDED 50.7°, 38.4°, 81.8°, 18.0°, 26.1°, 3.19, 3.32, 2.06, AND 3.92 DIMS | | | |
| | -11, -12, -13, -14, -15 ADDED LOCATIONS FOR Ø 1.000 THRU HOLES | | | |
| | -16 LIFTING BOLT WAS MANUFACTURED USING McMaster-CARR#91268A967 IS MANUFACTURED AS PER ASTM A354 (GRADE BD). DIMENSIONS AS PER ASME B18.2.1. DIM WAS 9.25 IS 9.00. DIM WAS 7.25±.030 IS 5.54-4.67. DIM WAS Ø .297 IS Ø 0.312. ADDED 0.867 DIM. REMOVED 8.65 DIM | | | |
| | -19 BUMPER WAS MANUFACTURED USING E3TZ-4730-A IS MANUFACTURED USING UHMW | | | |
| REV. | DESCRIPTION | | ECN # | BY |
| DESIGN | KPT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWN | KPT | | | |
| CHECKED | ZF | TOOL PART # | REV. D | |
| MFG. APPR. | DP | C250-C | SHEET 1 OF 23 | |
| APPROVED | WJP | TITLE | SCALE | |
| | | C250 CAGE ASSEMBLY | NTS | |
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| ITEM # | QTY | PART # | PART TITLE |
|--------|-----|---------------|--|
| -1 | 1 | C250-C-1 | C250 CAGE WELDMENT |
| -16 | 1 | C250-C-16 | LIFTING BOLT |
| -17 | 1 | C250-C-17 | LIFTING BUSHING |
| -18 | 1 | C250-C-18 | BUMPER ASSEMBLY |
| -20 | 1 | C250-C-20 | LIFTING NUT |
| 21 | 4 | AN12-61A | CAD. PLATED STEEL HEX BOLT 3/4"-16 X 5-3/16" GRIP LG. X 6-13/32" LG. |
| 22 | 1 | MS21042-6 | CAD. PLATED STEEL SELF-LOCKING NUT 3/8"-24 X 0.275" HT. |
| 23 | 4 | MS21044N12 | CAD PLATED STEEL SELF-LOCKING HEX NUT 3/4"-16 X 0.873" HT. |
| 24 | 2 | MS21299-24 | CAD. PLATED STEEL WASHER 1.504" ID. X 2.879" OD. X 0.062" THK. |
| 25 | 1 | MS24665-690 | CAD. PLATED STEEL COTTER PIN 5/16" DIA. X 4" LG. |
| 26 | 2 | NAS1149F0663P | CAD. PLATED STEEL WASHER 0.390" ID. X 0.625" OD. X 0.063" THK. |
| 27 | 8 | NAS1149F1290P | CAD PLATED STEEL WASHER 0.765" ID. X 1.312" OD. X 0.090" THK. |
| 28 | 1 | NAS1351-6-32P | CAD. PLATED STEEL SOCKET HEAD CAP SCREW 3/8"-24 X 2" LG. |

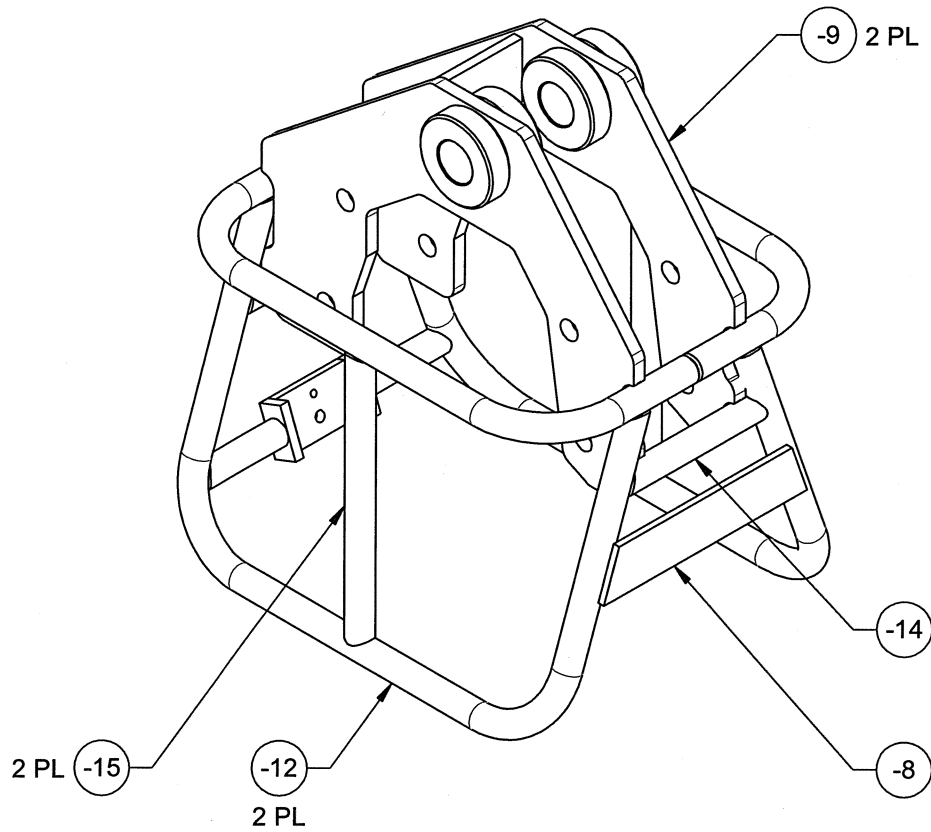


DETAIL A

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: X-TENSION STAMP T/N AND S/N, AS SHOWN, PER QSI 044 SECTION 6.2
7) ASSEMBLE AS SHOWN
8) TORQUE ITEM 22 TO 13-16 FT-LBS (160-190 IN-LBS)
9) INSTALL ITEMS -20 AND 23 HAND TIGHT
10) DO NOT FOLD ITEM 25

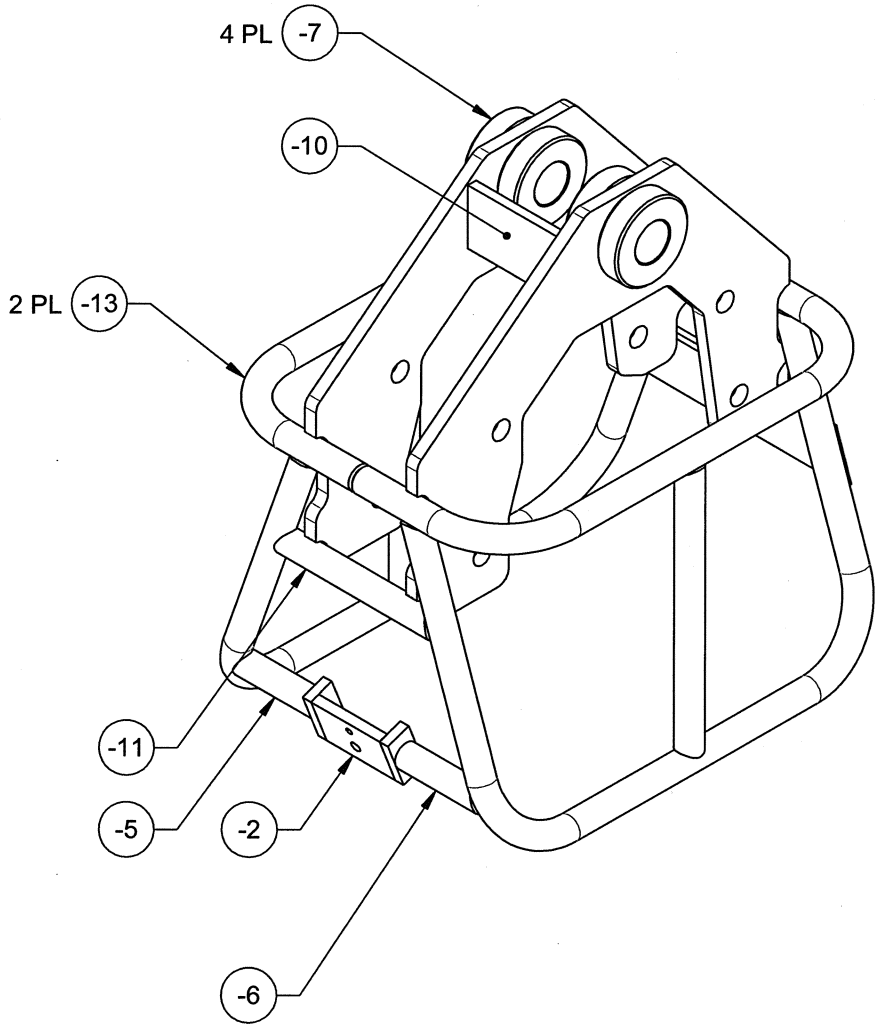
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|------------|------------|--|---------------|
| DESIGN | KPT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | KPT | | |
| CHECKED | ZF | TOOL PART # | REV. D |
| MFG. APPR. | DP | C250-C | SHEET 2 OF 23 |
| APPROVED | W | TITLE | SCALE |
| | | C250 CAGE ASSEMBLY | NTS |
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| ITEM # | QTY | PART # | PART TITLE |
|--------|-----|-----------|-------------------------|
| -2 | 1 | C250-C-2 | BUMPER BRACKET WELDMENT |
| -5 | 1 | C250-C-5 | LEFT HAND BUMPER TUBE |
| -6 | 1 | C250-C-6 | RIGHT HAND BUMPER TUBE |
| -7 | 4 | C250-C-7 | CAGE BOSS |
| -8 | 1 | C250-C-8 | FRONT PLATE |
| -9 | 2 | C250-C-9 | LIFTING PLATE |
| -10 | 1 | C250-C-10 | LIMITING PLATE |
| -11 | 1 | C250-C-11 | MID TUBE |
| -12 | 2 | C250-C-12 | SIDE HOOP |
| -13 | 2 | C250-C-13 | TOP RING |
| -14 | 1 | C250-C-14 | TOP TUBE |
| -15 | 2 | C250-C-15 | SIDE TUBE |



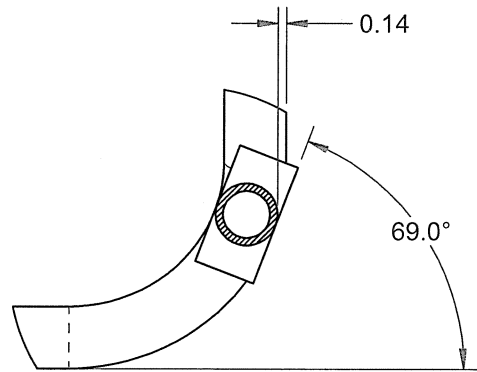
C250-C-1 C250 CAGE WELDMENT

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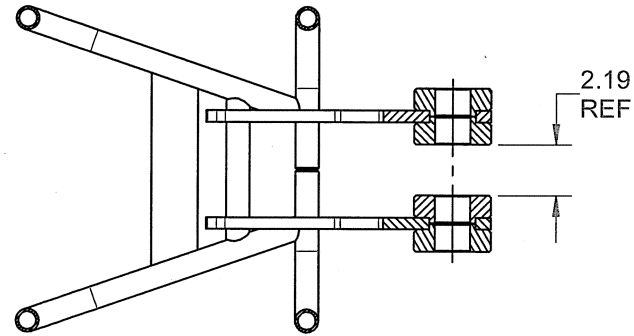


- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: PRIME AND PAINT RED AS PER QSI 005 SECTION 4.2.2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) REMOVE ALL WELD SPATTERS
 - 9) NOTCH ENDS OF ITEMS -5, -6, -11, -12, -14, AND -15 AS REQUIRED, PRIOR TO WELDING

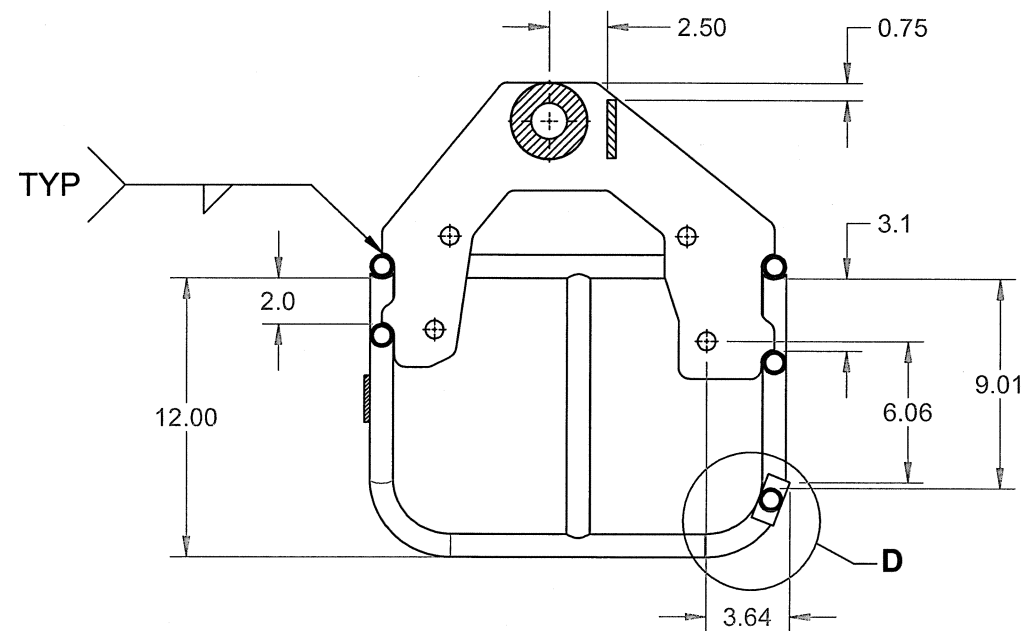
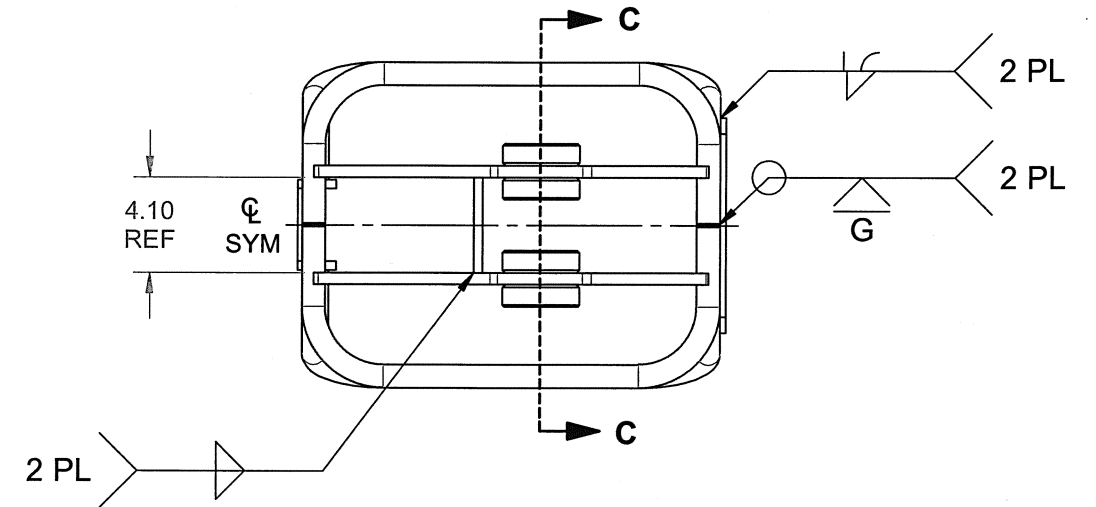
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|------------|------------|---|---------------|
| DESIGN | KPT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | KPT | | |
| CHECKED | ZF | TOOL PART # | REV. D |
| MFG. APPR. | DP | C250-C | SHEET 3 OF 23 |
| APPROVED | | TITLE | SCALE |
| | | C250 CAGE ASSEMBLY | NTS |
| DATE | 2019-10-21 | COPYRIGHT © 2019 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |



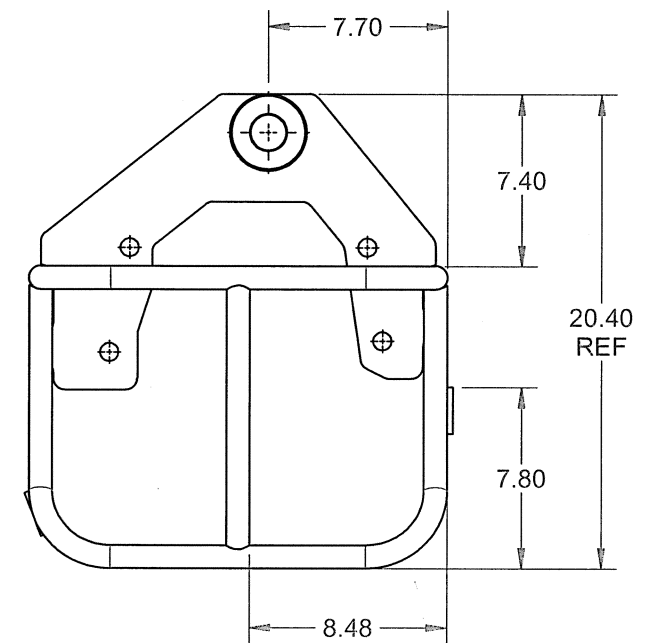
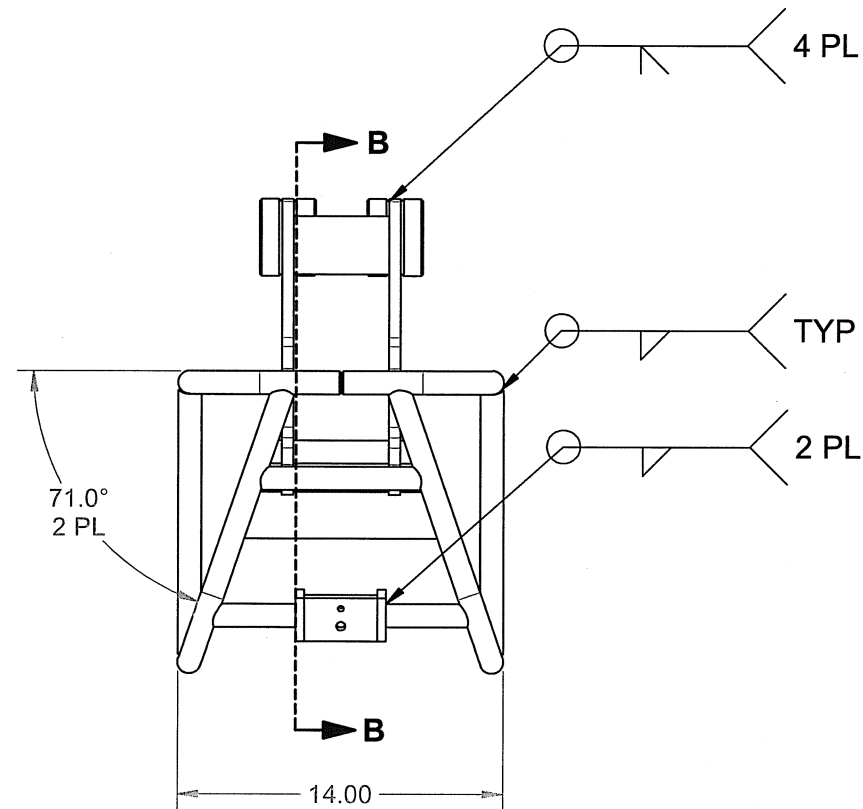
DETAIL D



SECTION C-C

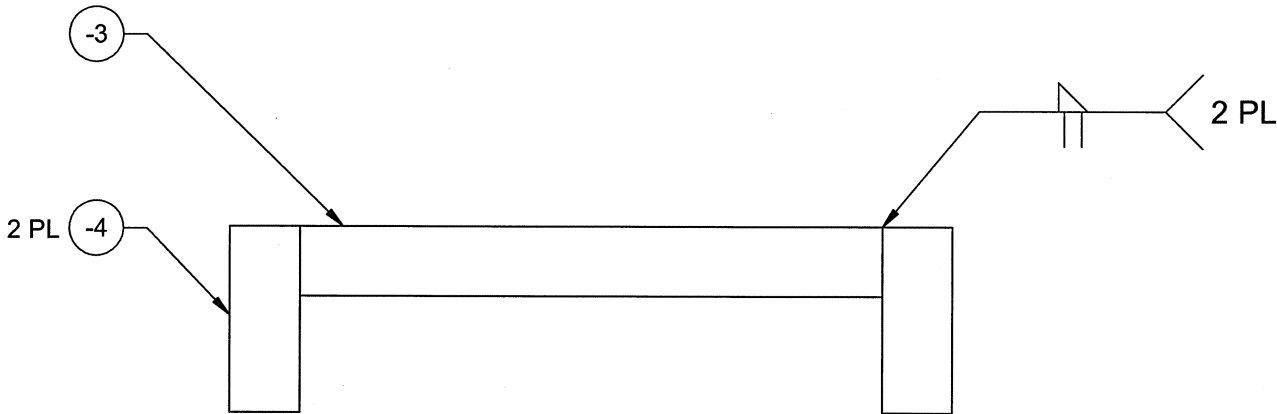
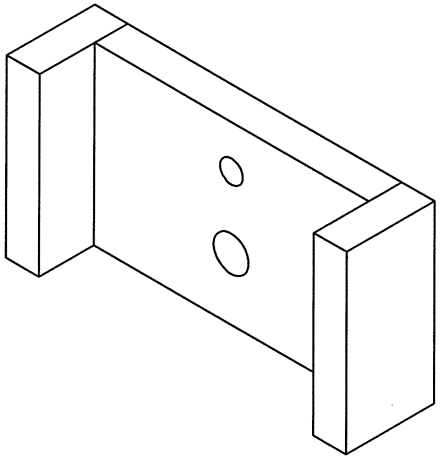
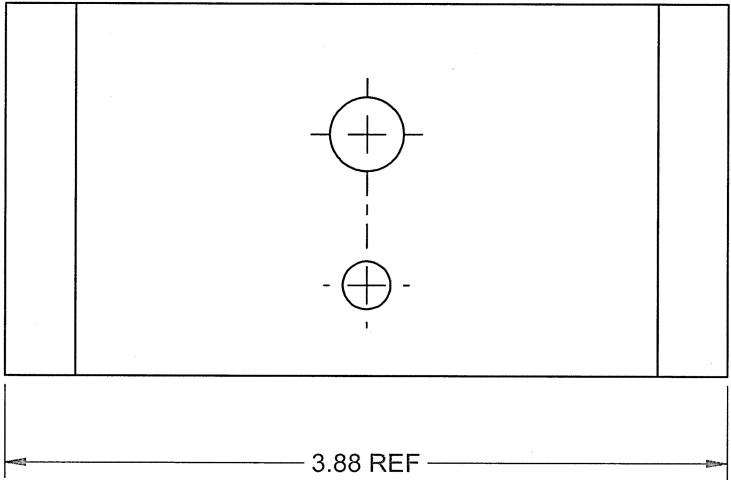


SECTION B-B



| | | | |
|------------|------------|---|---------------|
| DESIGN | KPT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | KPT | | |
| CHECKED | ZF | TOOL PART # | REV. D |
| MFG. APPR. | DP | C250-C | SHEET 4 OF 23 |
| APPROVED | | TITLE | SCALE |
| | | C250 CAGE ASSEMBLY | NTS |
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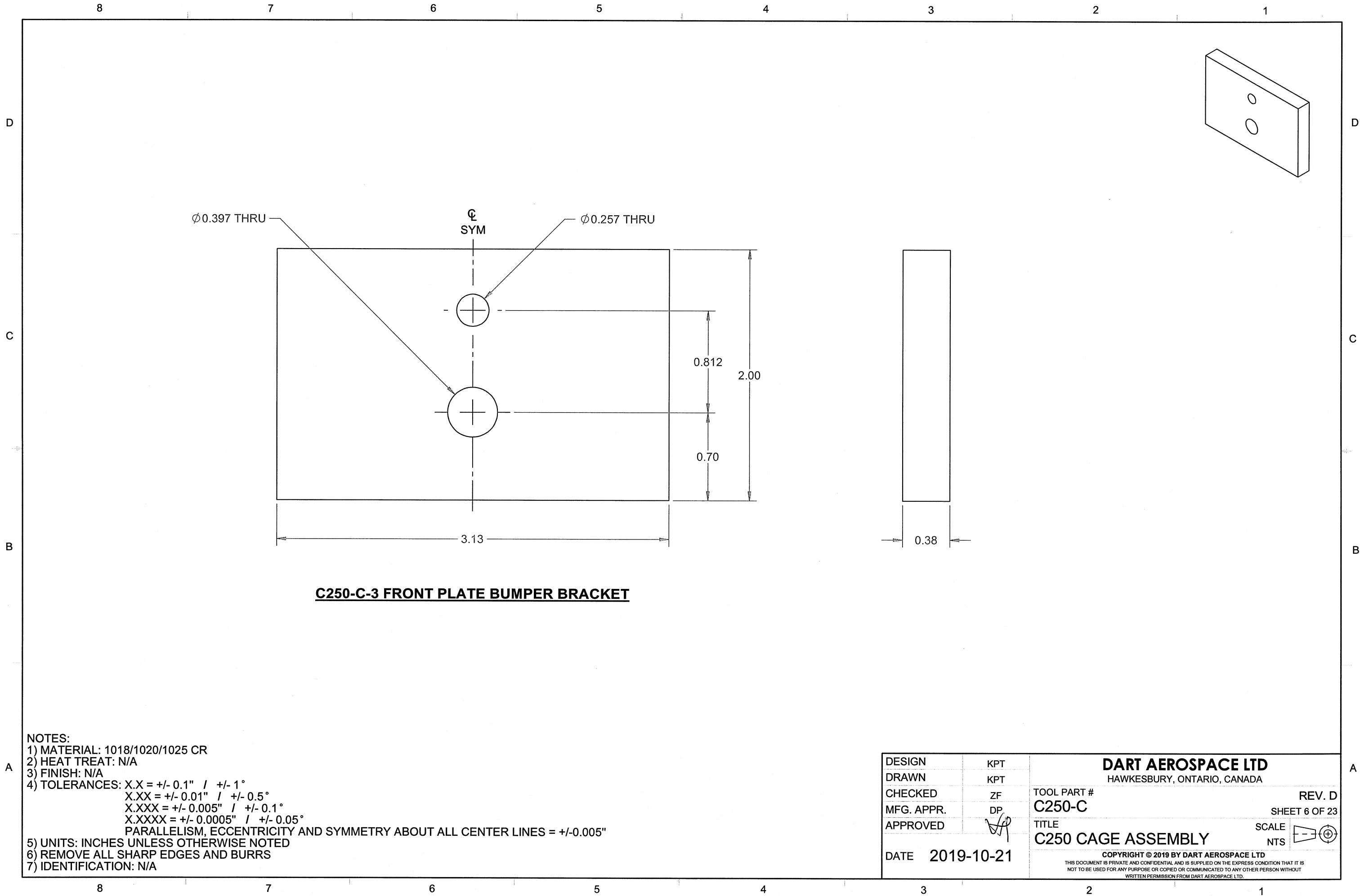
| ITEM # | QTY | PART # | PART TITLE |
|--------|-----|----------|----------------------------|
| -3 | 1 | C250-C-3 | FRONT PLATE BUMPER BRACKET |
| -4 | 2 | C250-C-4 | SIDE PLATE BUMPER BRACKET |

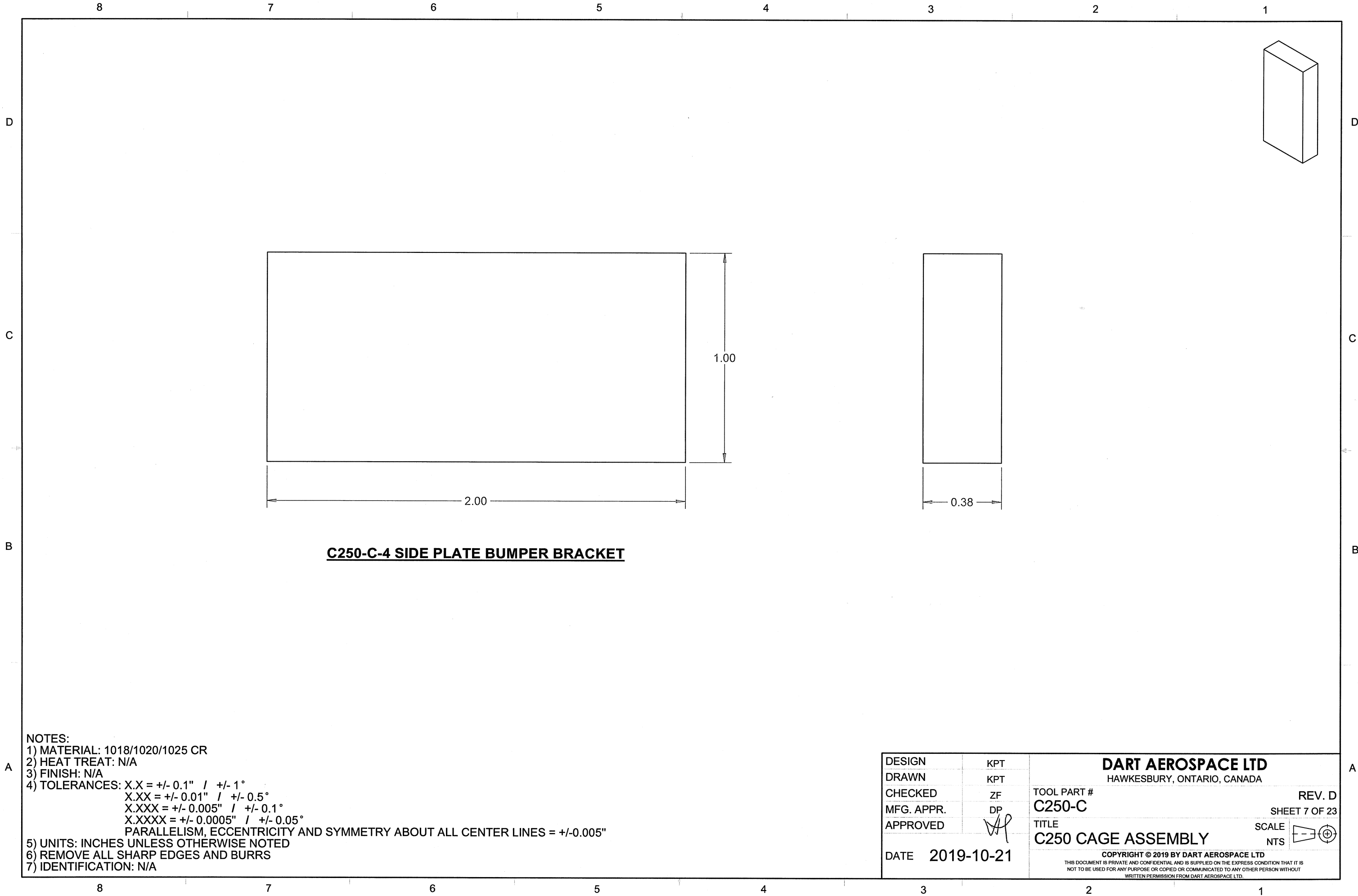


C250-C-2 BUMPER BRACKET WELDMENT

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A
7) ASSEMBLE AS SHOWN
8) REMOVE ALL WELD SPATTERS

| | | | |
|--|-----|--|---------------|
| DESIGN | KPT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | KPT | | |
| CHECKED | ZF | TOOL PART # | REV. D |
| MFG. APPR. | DP | C250-C | SHEET 5 OF 23 |
| APPROVED | | TITLE | SCALE |
| DATE 2019-10-21 | | C250 CAGE ASSEMBLY | NTS |
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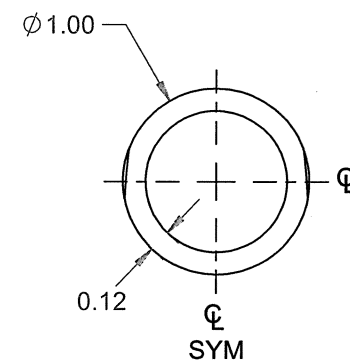
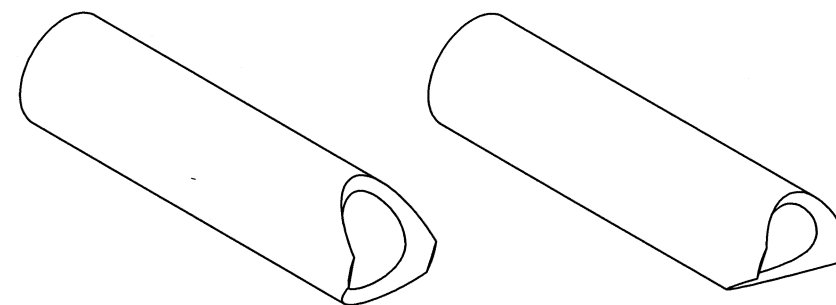
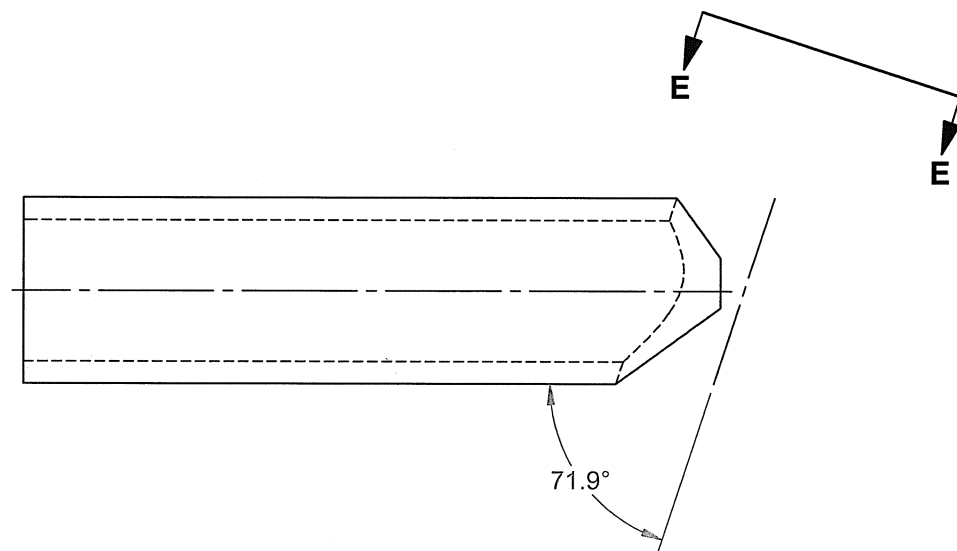
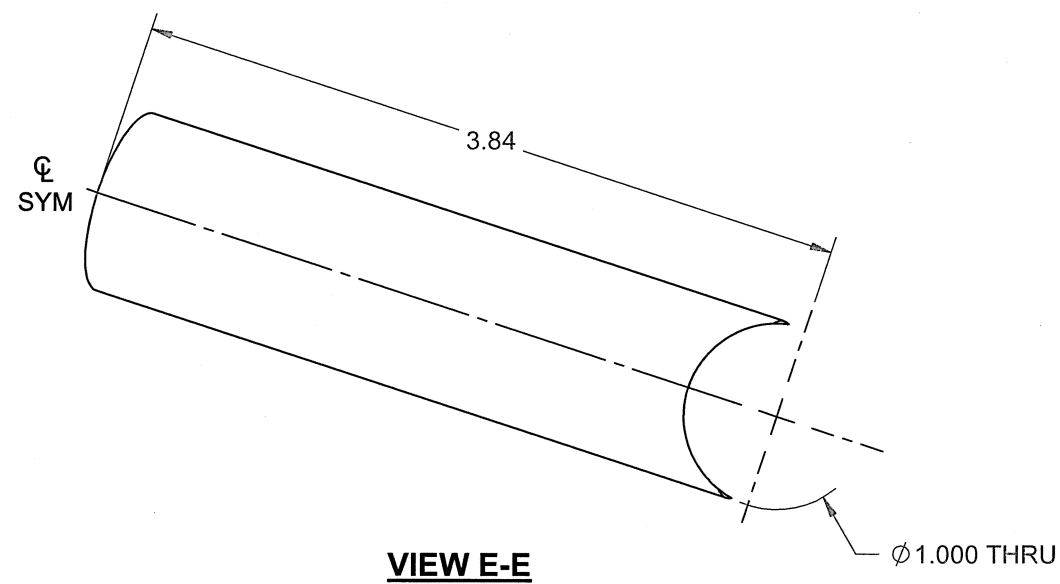
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C250-C-5 LEFT HAND BUMPER TUBE

NOTES:

1) MATERIAL: A513 TYPE 5 DOM TUBING

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°



X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

| | | | |
|------------|---|---|---|
| DESIGN | KPT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | KPT | | |
| CHECKED | ZF | TOOL PART # C250-C | REV. D |
| MFG. APPR. | DP | TITLE C250 CAGE ASSEMBLY | SHEET 8 OF 23 |
| APPROVED |  | SCALE NTS |  |
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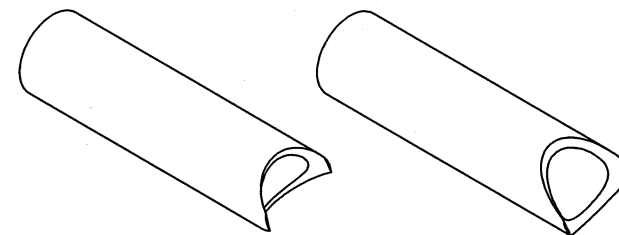
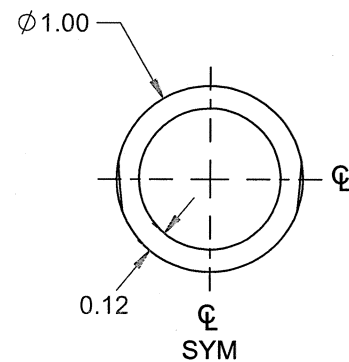
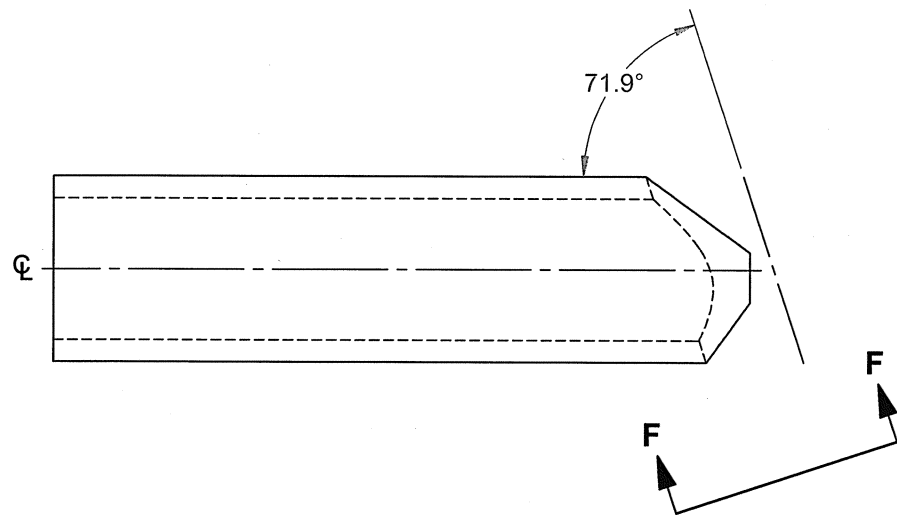
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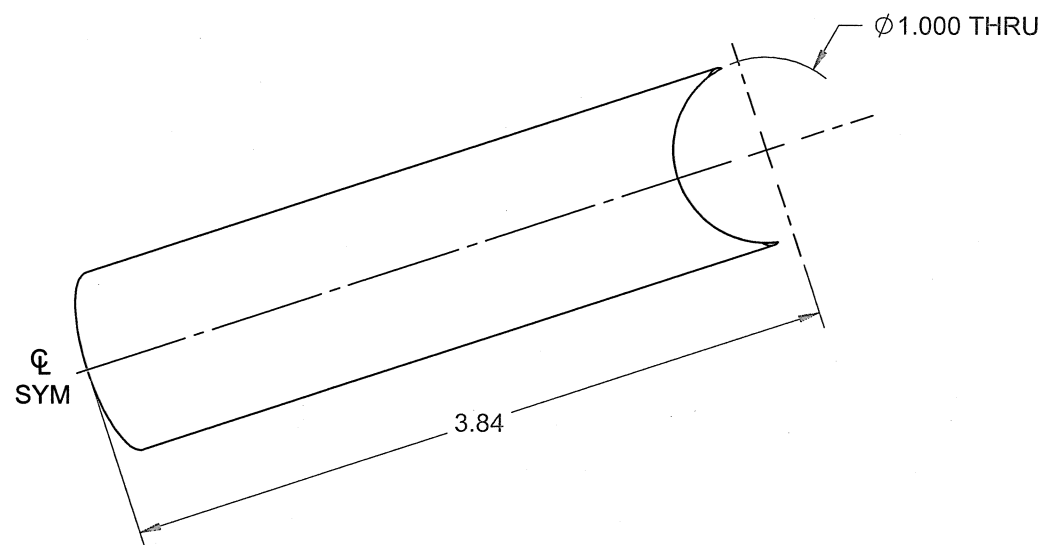
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C250-C-6 RIGHT HAND BUMPER TUBE



VIEW F-F

- NOTES:
- 1) MATERIAL: A513 TYPE 5 DOM TUBING
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

| | | | |
|---|------------|--|---------------|
| DESIGN | KPT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | KPT | | |
| CHECKED | ZF | TOOL PART # | REV. D |
| MFG. APPR. | DP | C250-C | SHEET 9 OF 23 |
| APPROVED | | TITLE | SCALE |
| DATE | 2019-10-21 | C250 CAGE ASSEMBLY | NTS |
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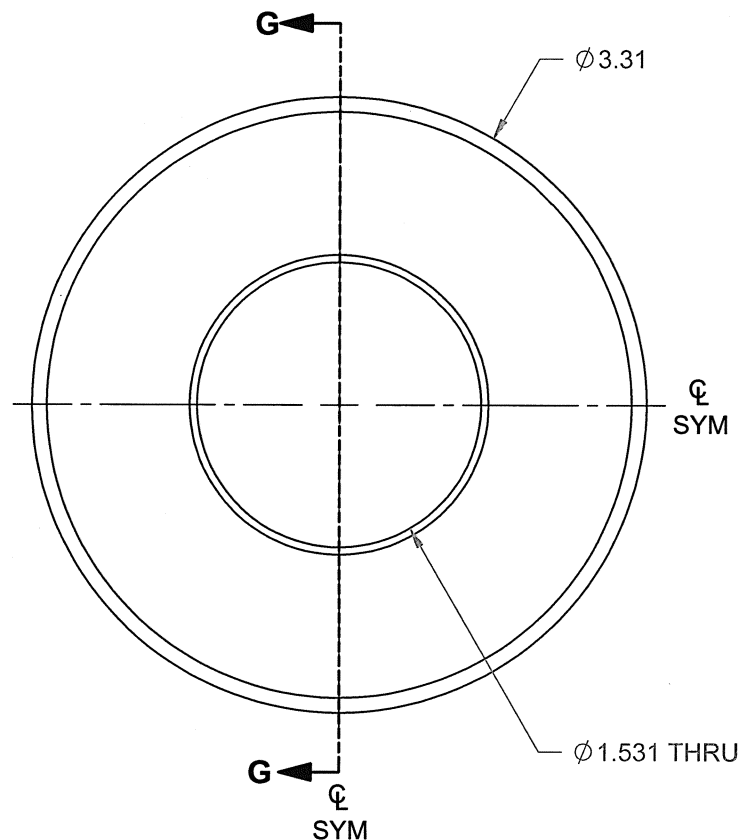
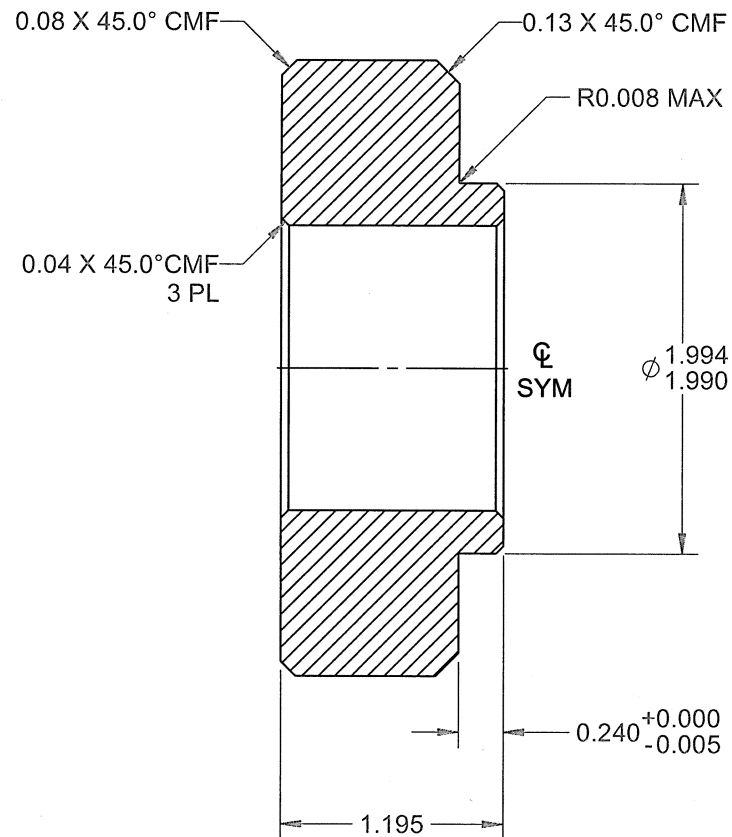
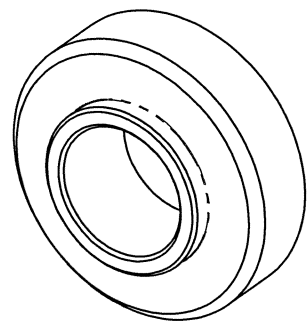
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**C250-C-7 CAGE BOSS****SECTION G-G**

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
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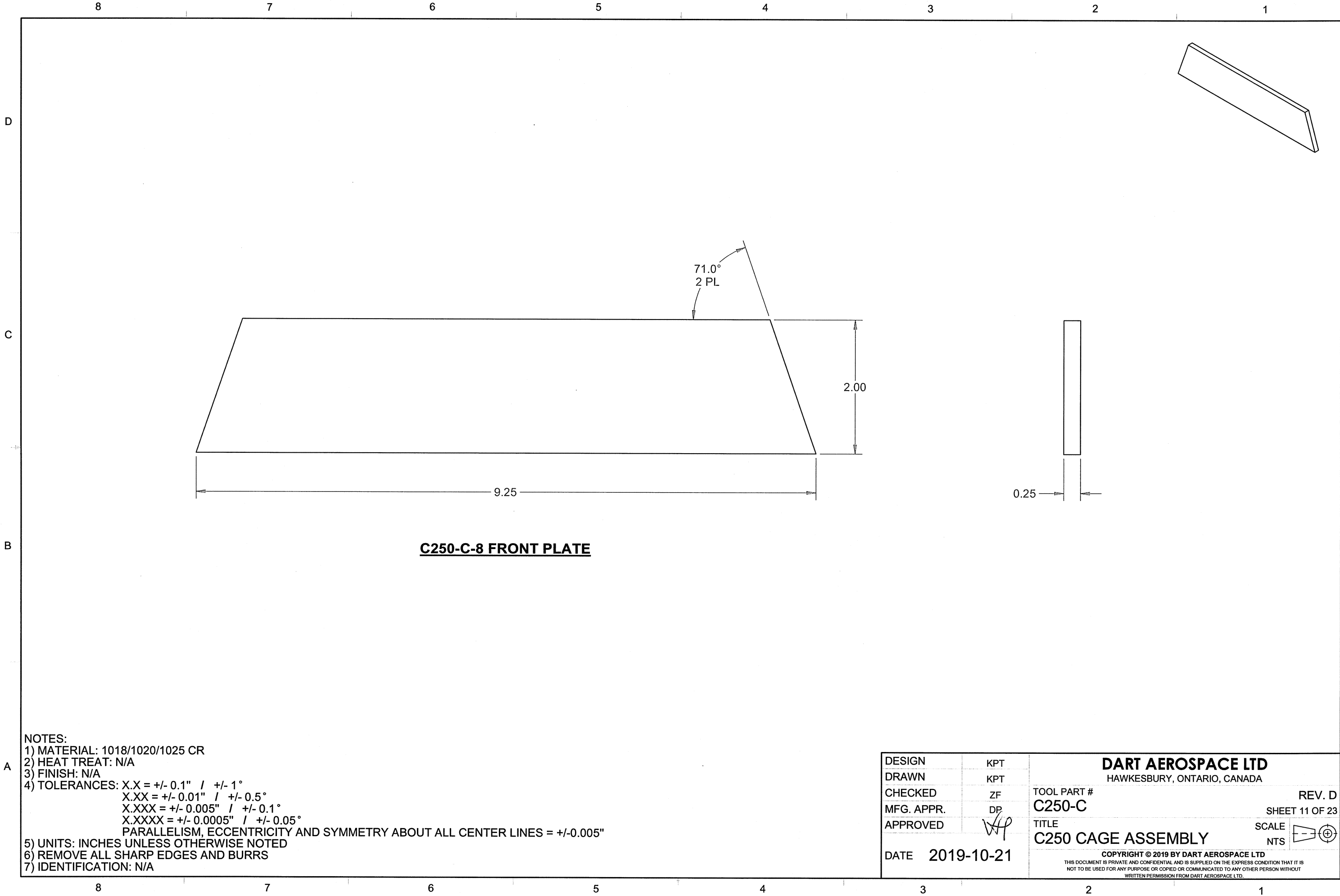
B

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NOTES:

- 1) MATERIAL: 1018/1020/1025 CR
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

| | | | |
|--|---|--|---|
| DESIGN | KPT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | KPT | | |
| CHECKED | ZF | TOOL PART # | REV. D |
| MFG. APPR. | DP | C250-C | SHEET 10 OF 23 |
| APPROVED |  | TITLE | SCALE |
| DATE | 2019-10-21 | C250 CAGE ASSEMBLY | NTS  |
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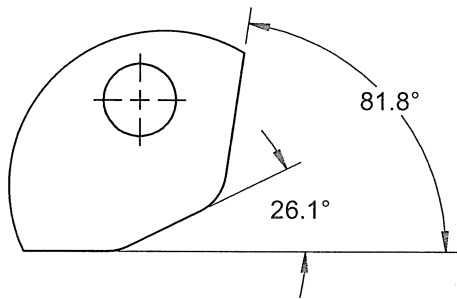
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D

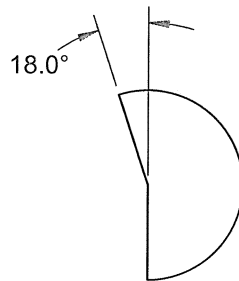
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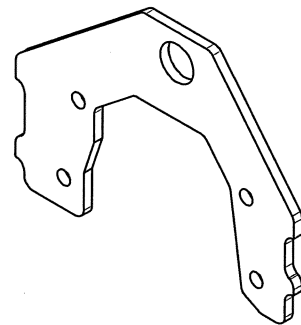
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DETAIL J



DETAIL H

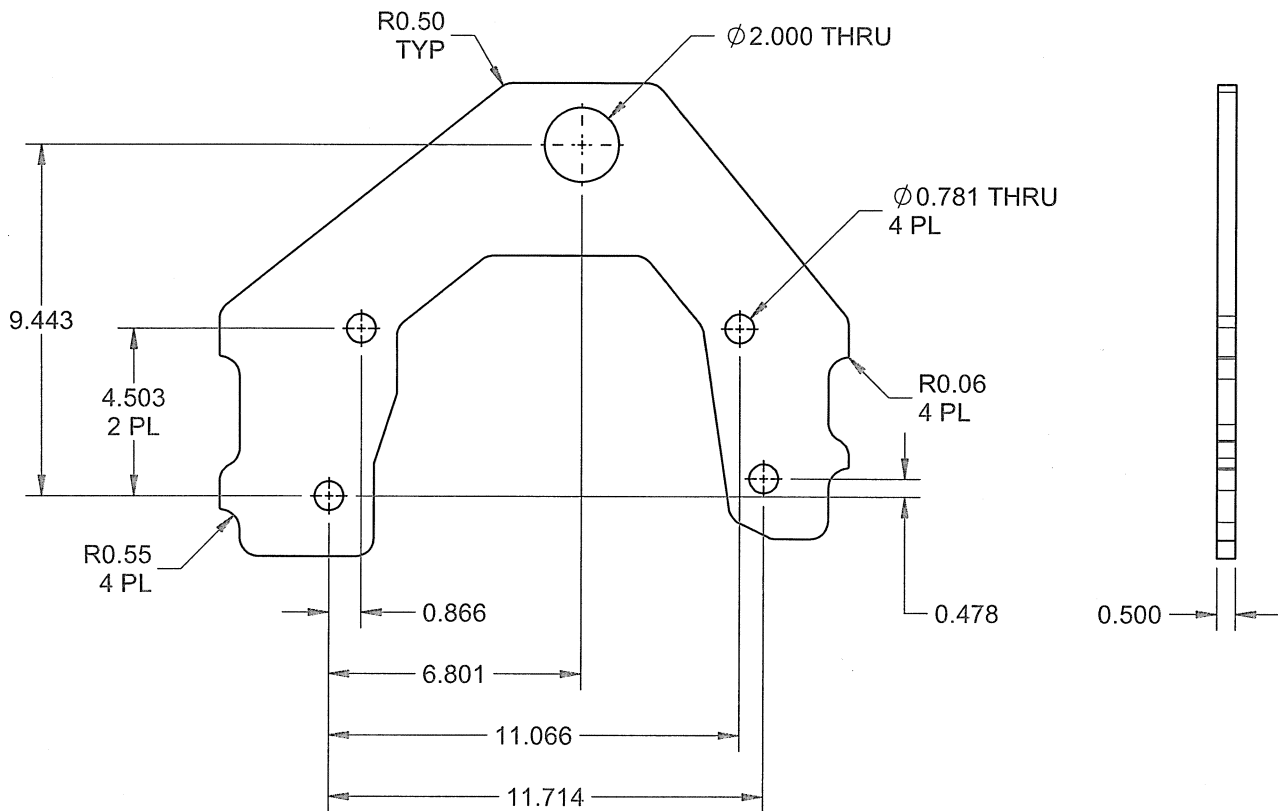


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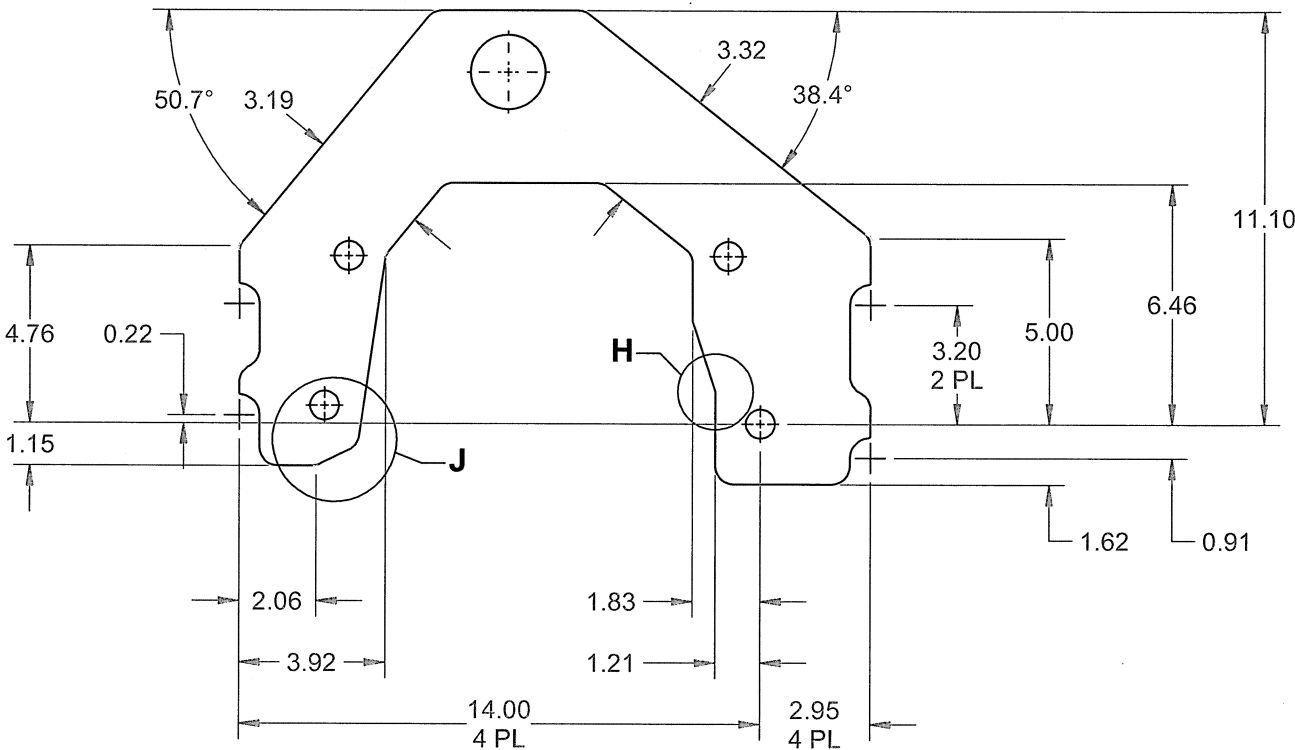
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
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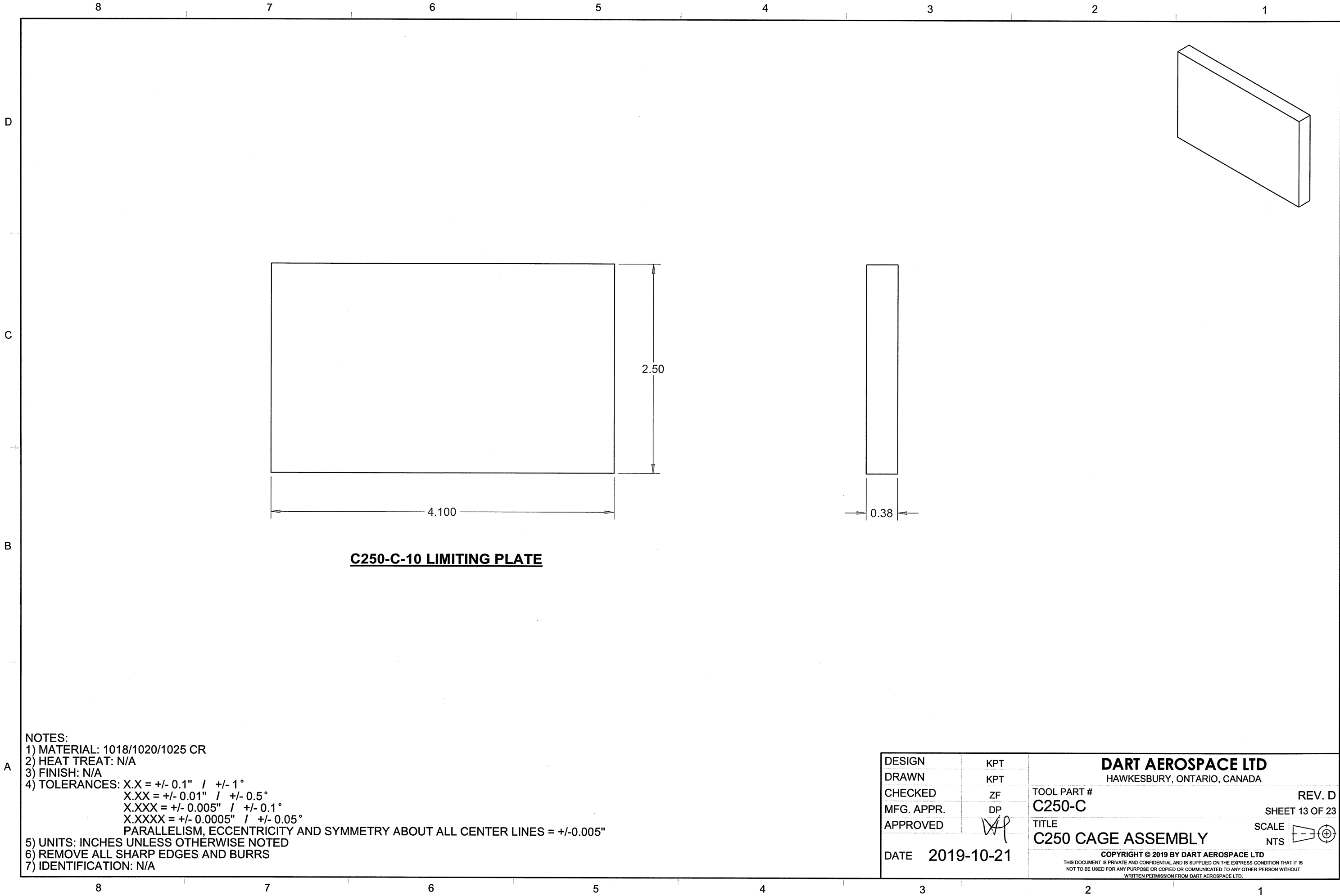


C250-C-9 LIFTING PLATE



- NOTES:
- 1) MATERIAL: 1018/1020/1025 CR
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

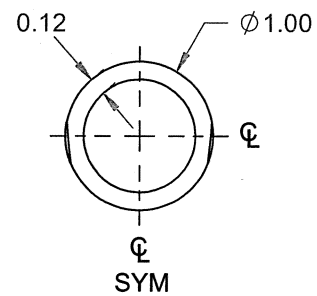
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|--|---|--|---|
| DESIGN | KPT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | KPT | | |
| CHECKED | ZF | TOOL PART # | REV. D |
| MFG. APPR. | DP | C250-C | SHEET 12 OF 23 |
| APPROVED |  | TITLE | SCALE |
| DATE | 2019-10-21 | C250 CAGE ASSEMBLY | NTS  |
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8 7 6 5 4 3 2 1

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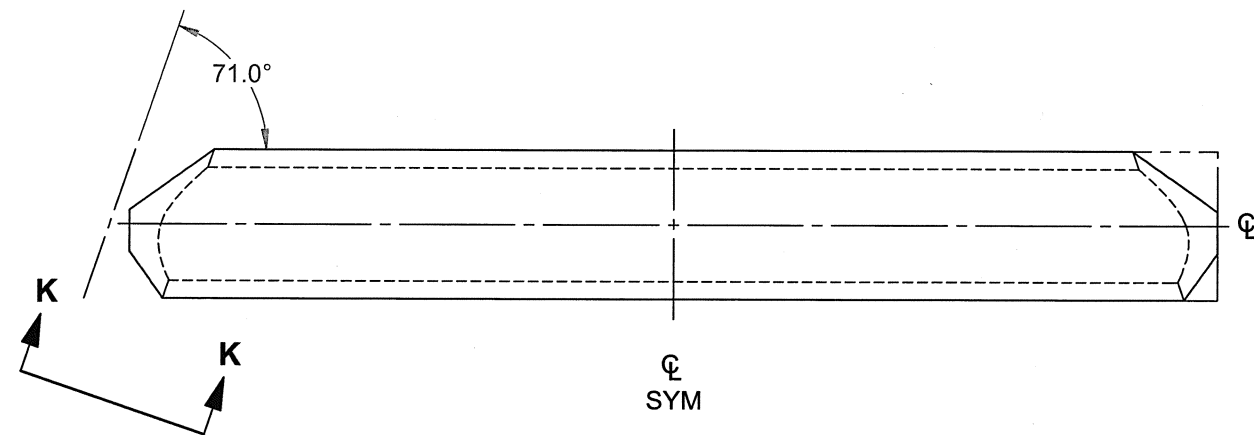
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C250-C-11 MID TUBE

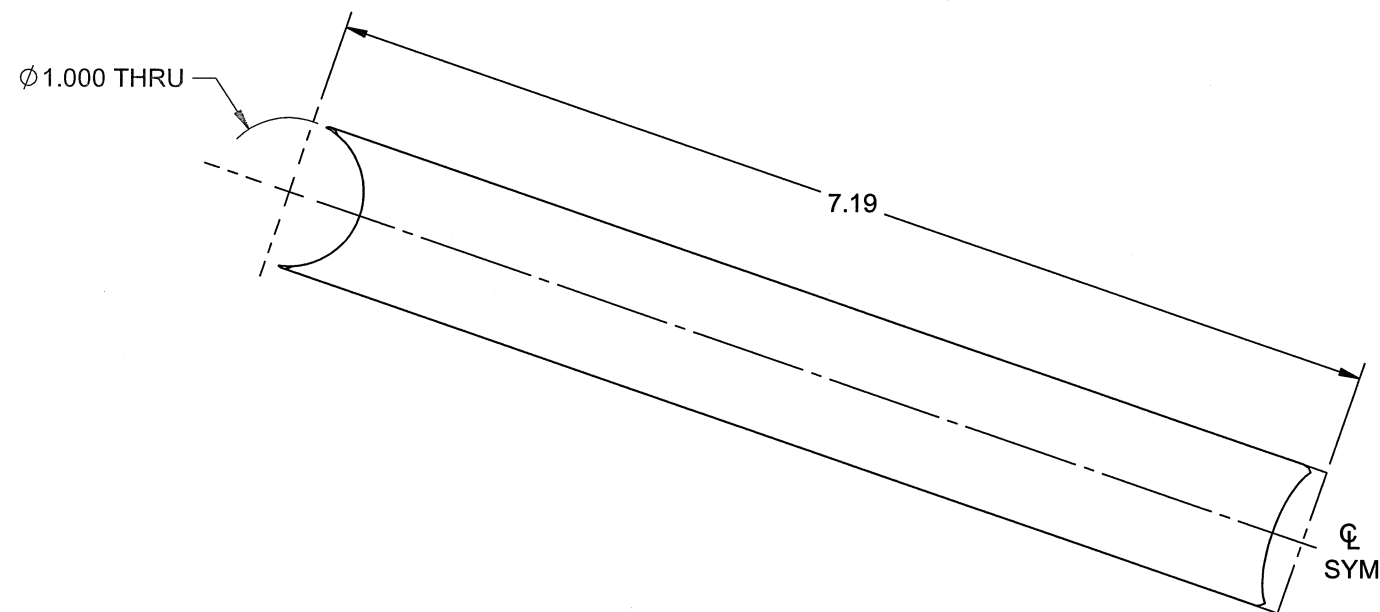
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VIEW K-K
2 PL

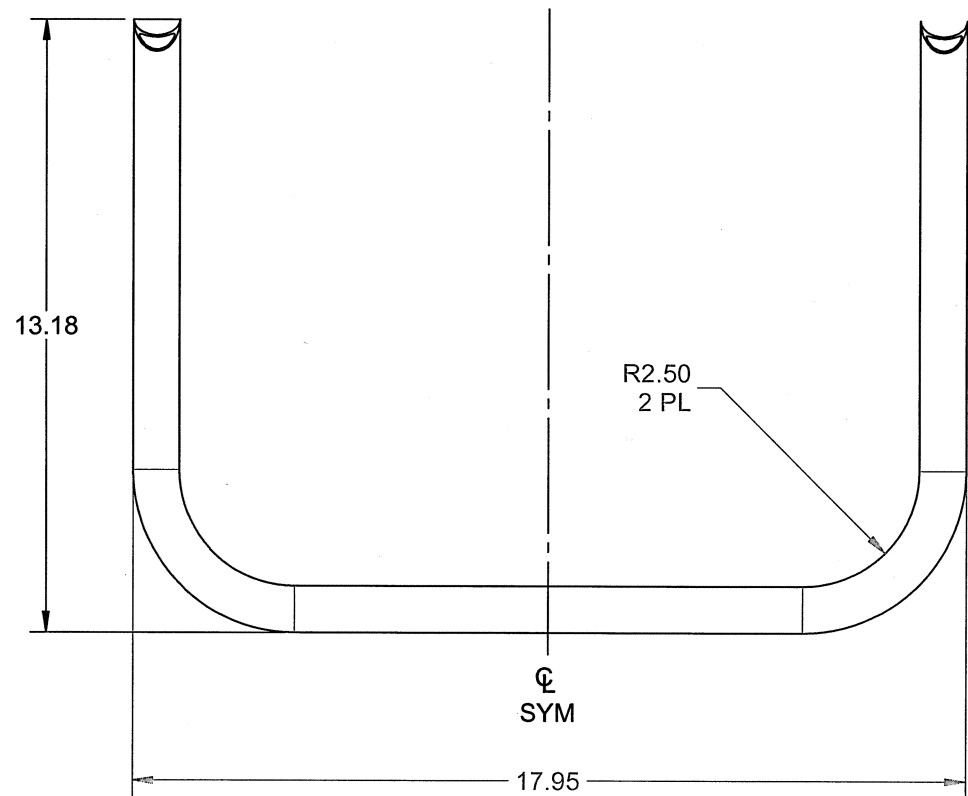
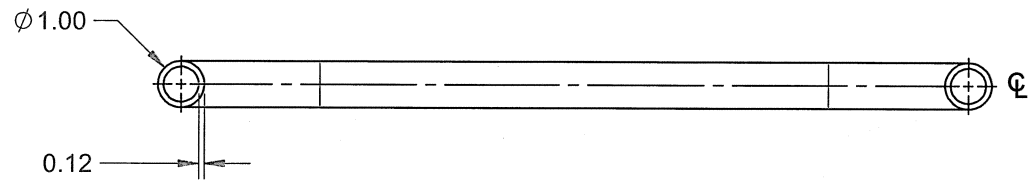
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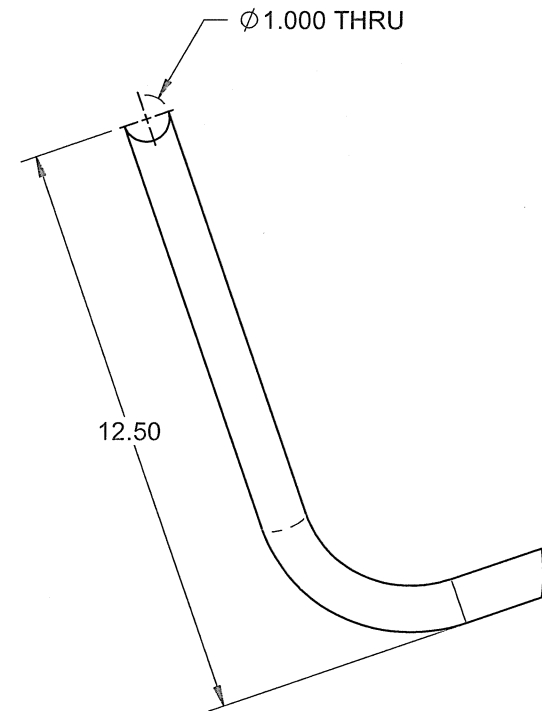
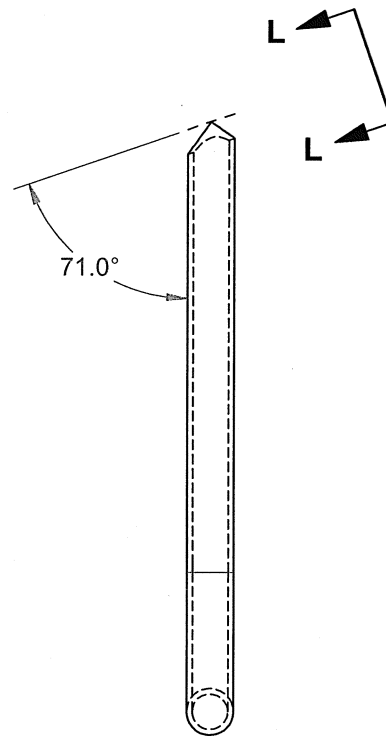
- NOTES:
- 1) MATERIAL: A513 TYPE 5 DOM TUBING
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

8 7 6 5 4 3 2 1

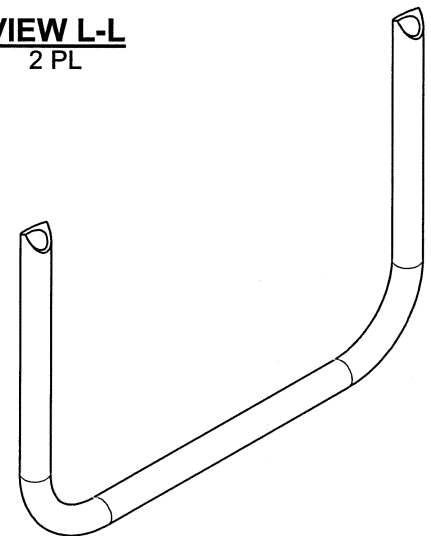
| | | | | |
|--|---|--|---------------------------|--|
| DESIGN | KPT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | REV. D |
| DRAWN | KPT | | | |
| CHECKED | ZF | TOOL PART # | C250-C | SHEET 14 OF 23 |
| MFG. APPR. | DP | | | |
| APPROVED |  | TITLE | C250 CAGE ASSEMBLY | SCALE NTS  |
| DATE | 2019-10-21 | | | |
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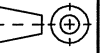
C250-C-12 SIDE HOOP



VIEW L-L
2 PL



- NOTES:
- 1) MATERIAL: A513 TYPE 5 DOM TUBING
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

| | | | |
|--|---|--|---|
| DESIGN | KPT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | KPT | | |
| CHECKED | ZF | TOOL PART # | REV. D |
| MFG. APPR. | DP | C250-C | SHEET 15 OF 23 |
| APPROVED |  | TITLE | SCALE |
| DATE | 2019-10-21 | C250 CAGE ASSEMBLY | NTS  |
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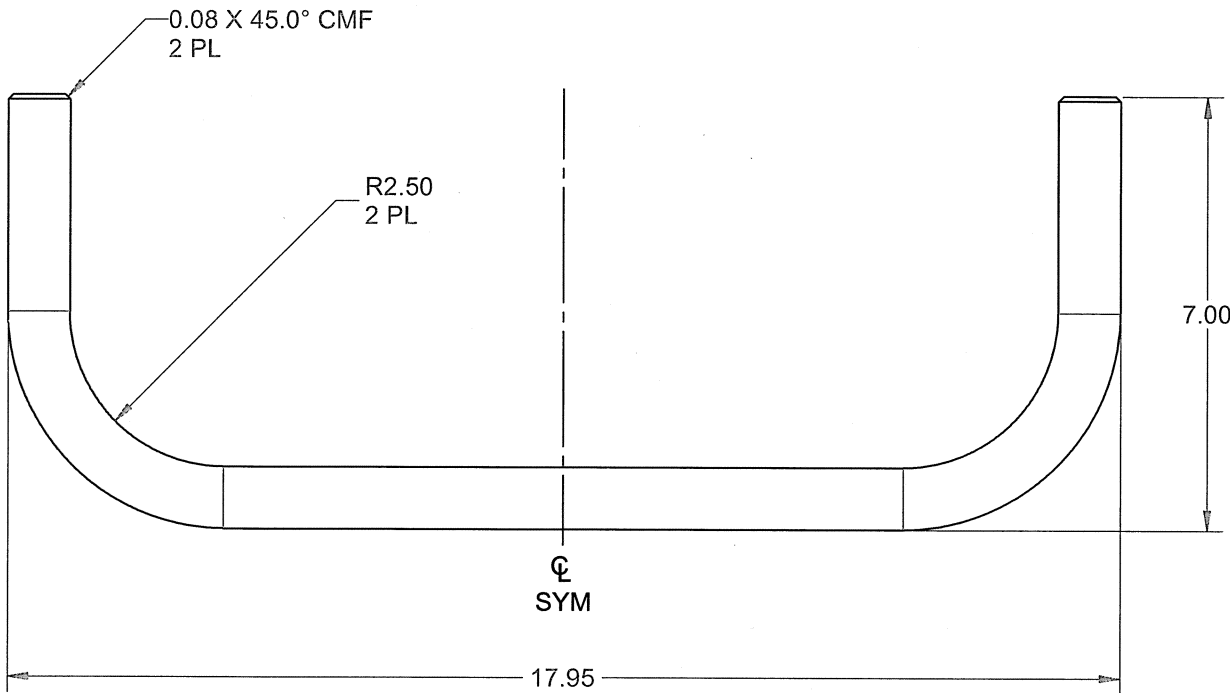
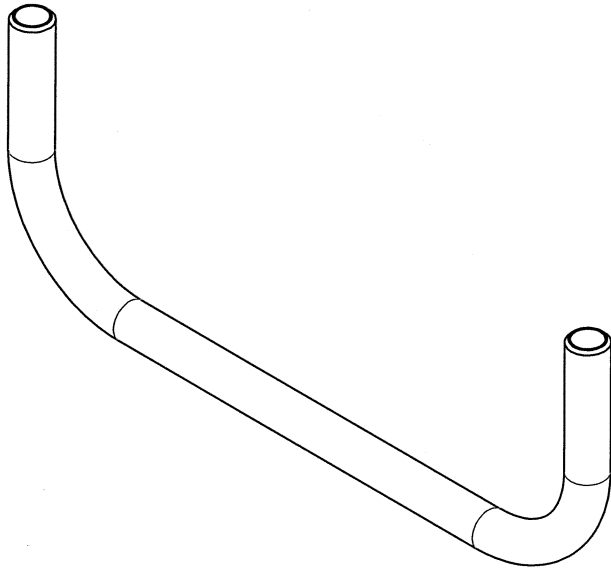
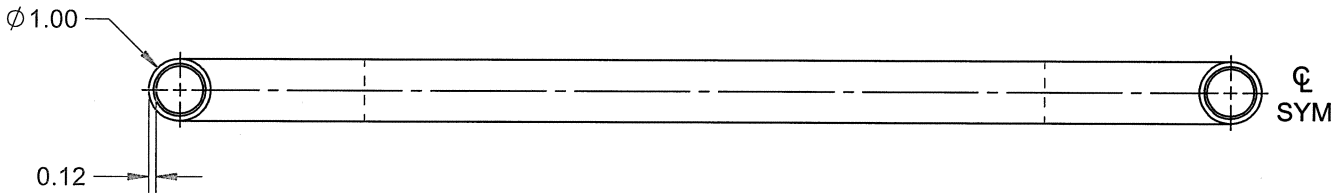
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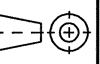
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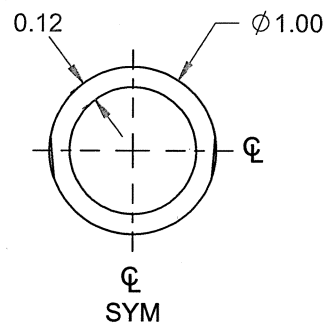
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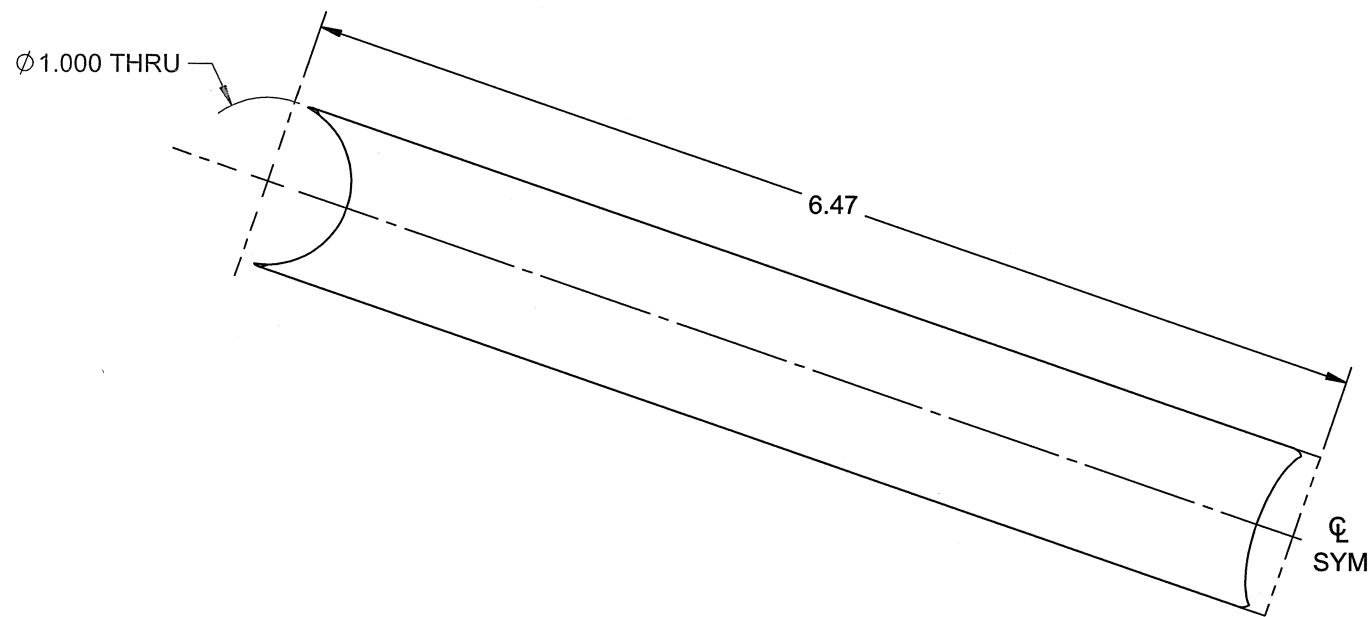
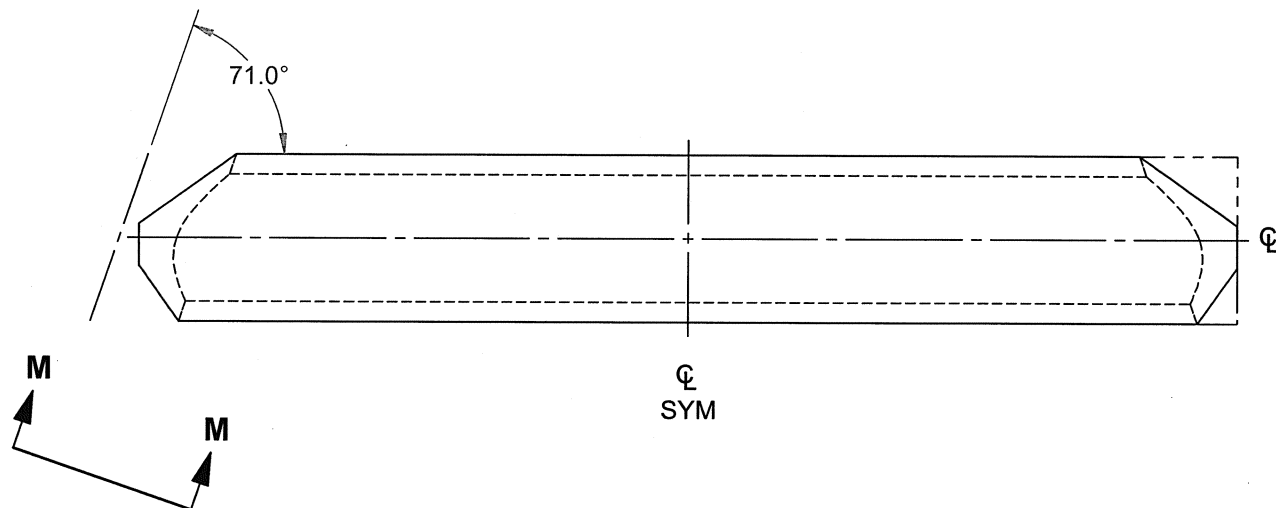
C250-C-13 TOP RING

NOTES:
1) MATERIAL: A513 TYPE 5 DOM TUBING
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: N/A

| | | | |
|------------|---|---|---|
| DESIGN | KPT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | KPT | | |
| CHECKED | ZF | TOOL PART # C250-C | REV. D |
| MFG. APPR. | DP | TITLE C250 CAGE ASSEMBLY | SHEET 16 OF 23 |
| APPROVED |  | SCALE NTS |  |
| DATE | 2019-10-21 | COPYRIGHT © 2019 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |



C250-C-14 TOP TUBE



VIEW M-M
2 PL

- NOTES:
- 1) MATERIAL: A513 TYPE 5 DOM TUBING
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

| | | | |
|------------|------------|---|----------------|
| DESIGN | KPT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | KPT | | |
| CHECKED | ZF | TOOL PART # | REV. D |
| MFG. APPR. | DP | C250-C | SHEET 17 OF 23 |
| APPROVED | | TITLE | SCALE |
| | | C250 CAGE ASSEMBLY | NTS |
| DATE | 2019-10-21 | COPYRIGHT © 2019 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

8 7 6 5 4 3 2 1

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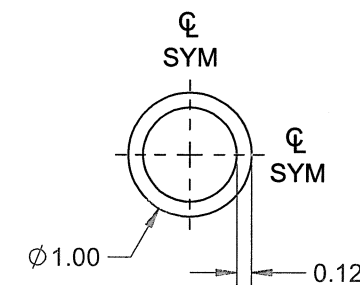
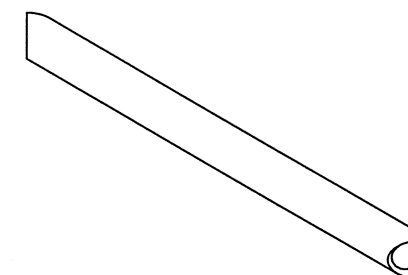
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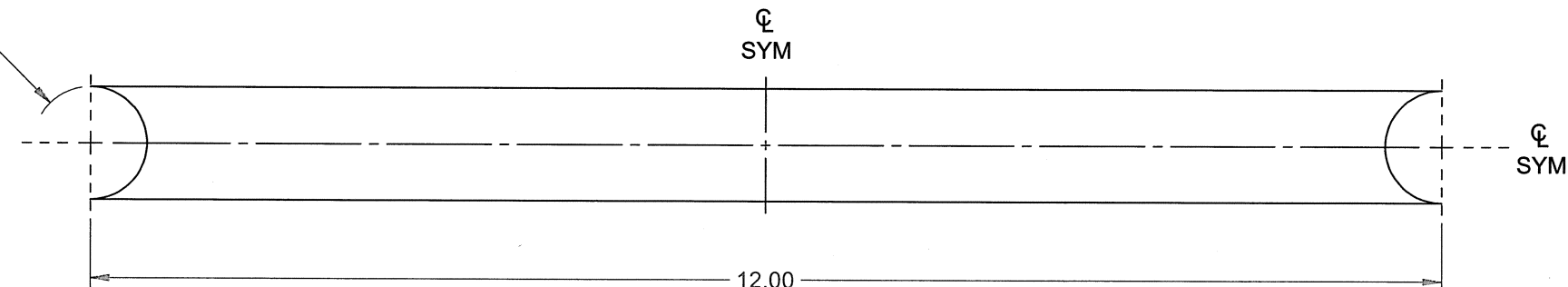
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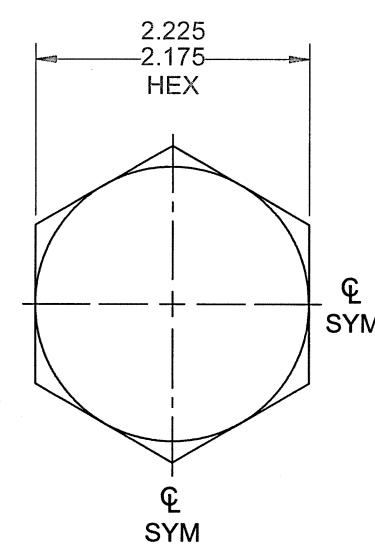
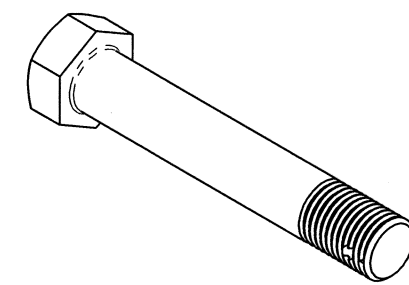
C250-C-15 SIDE TUBE

- NOTES:
- 1) MATERIAL: A513 TYPE 5 DOM TUBING
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

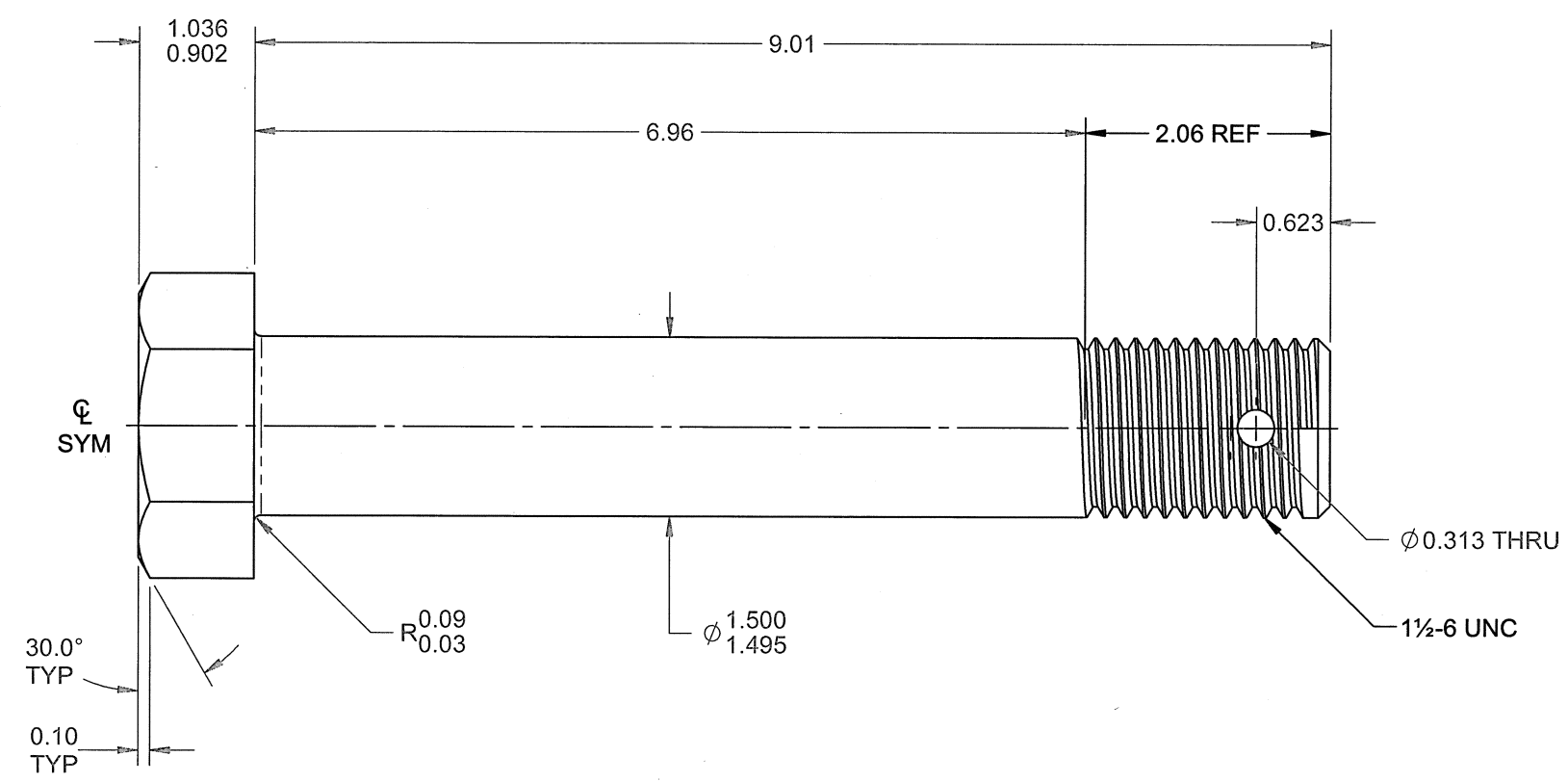
| | | | |
|--|-----|--|----------------|
| DESIGN | KPT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | KPT | | |
| CHECKED | ZF | TOOL PART # | REV. D |
| MFG. APPR. | DP | C250-C | SHEET 18 OF 23 |
| APPROVED | | TITLE | SCALE |
| DATE 2019-10-21 | | C250 CAGE ASSEMBLY | NTS |
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8 7 6 5 4 3 2 1



C250-C-16 LIFTING BOLT
8



- NOTES:
- 1) MATERIAL: SEE NOTE 8
 - 2) HEAT TREAT: SEE NOTE 8
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A
 - 8) LIFTING BOLT MUST CONFORM TO ASTM A354 (GRADE BD)

| | | | |
|------------|------------|--|----------------|
| DESIGN | KPT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | KPT | | |
| CHECKED | ZF | TOOL PART # | REV. D |
| MFG. APPR. | DP | C250-C | SHEET 19 OF 23 |
| APPROVED | WP | TITLE | SCALE |
| | | C250-C AGE ASSEMBLY | NTS |
| DATE | 2019-10-21 | COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

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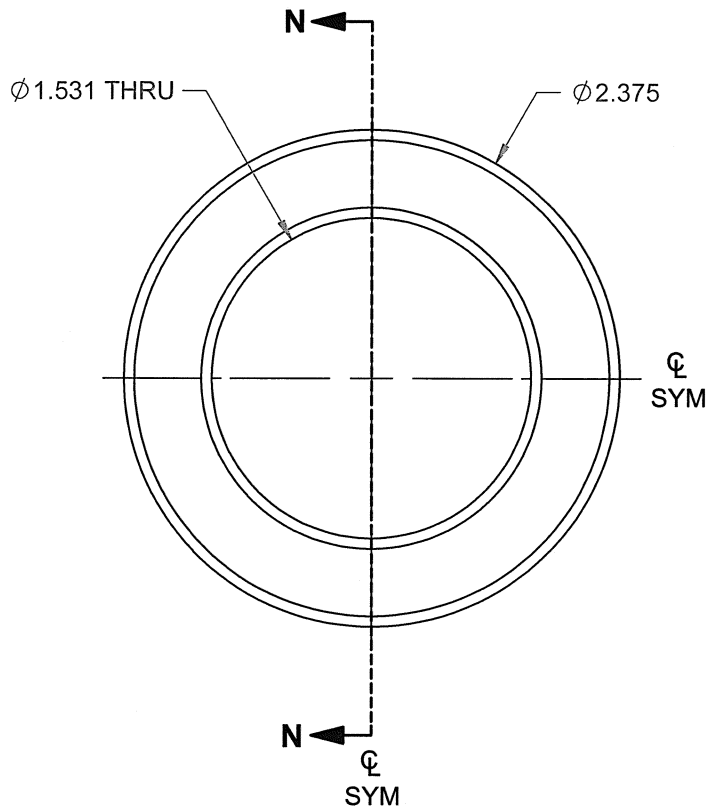
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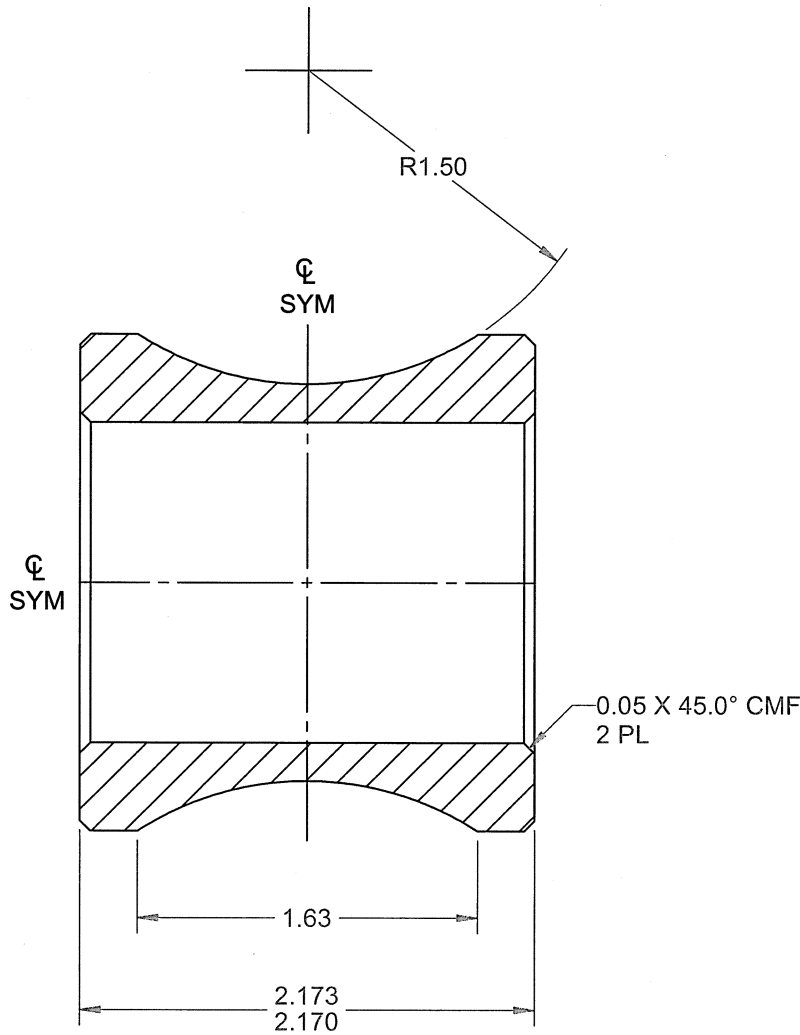
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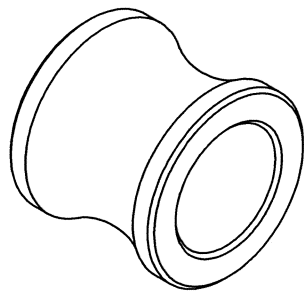
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C250-C-17 LIFTING BUSHING



SECTION N-N





D

C

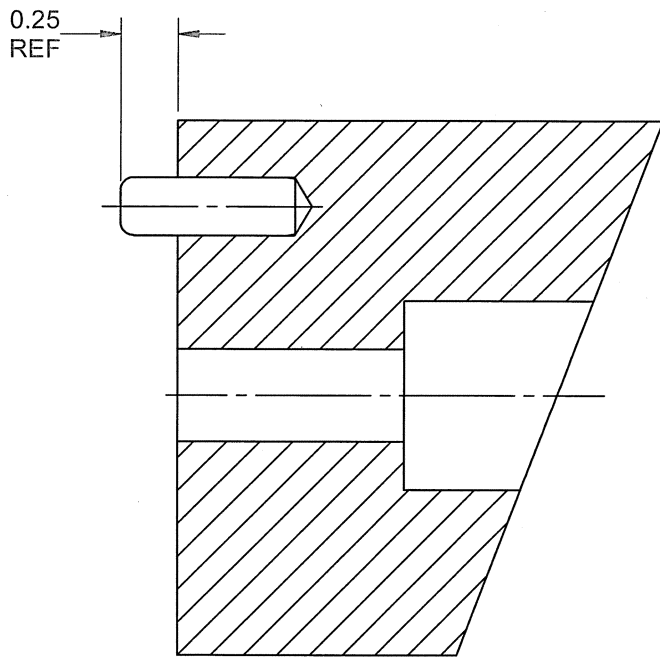
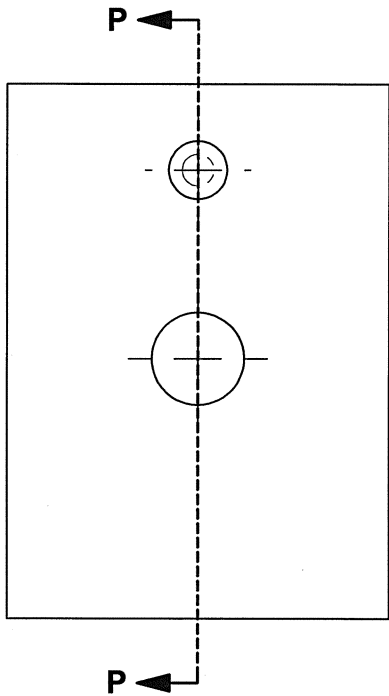
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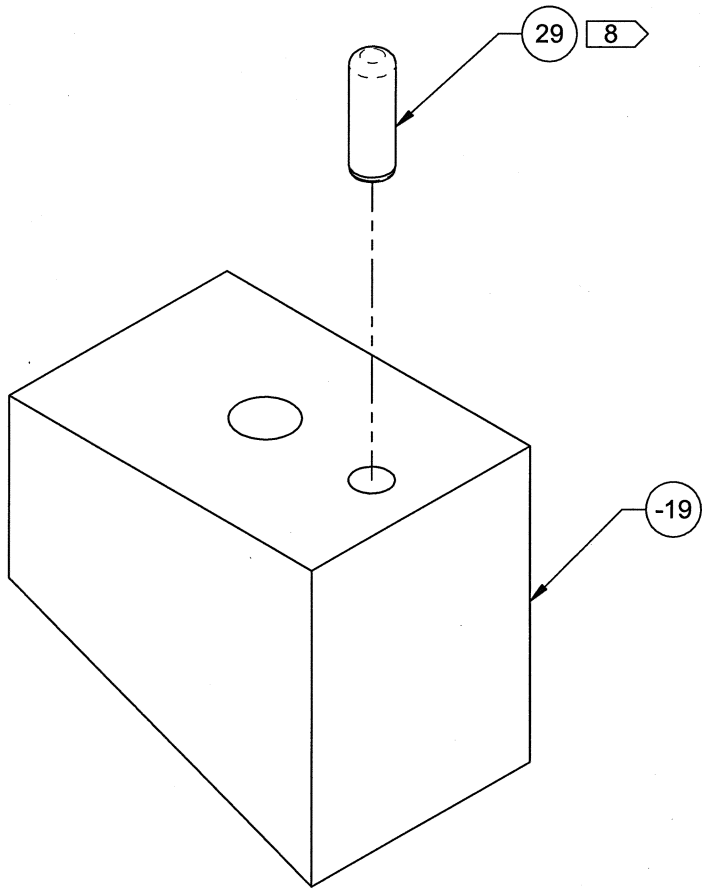
- NOTES:
- 1) MATERIAL: 4140 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: NICKEL PLATE PER MIL-C-26074 CLASS 2 GRADE B OR QQ-N-290A CLASS 2 GRADE E
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

| | | | | | |
|--|---|--|--------|--------|---|
| DESIGN | KPT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | REV. D | |
| DRAWN | KPT | | | | |
| CHECKED | ZF | TOOL PART # | C250-C | | |
| MFG. APPR. | DP | TITLE | | | |
| APPROVED |  | C250 CAGE ASSEMBLY | SCALE | |  |
| DATE | 2019-10-21 | NTS | | | |
| SHEET 20 OF 23 | | | | | |
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| ITEM # | QTY | PART # | PART TITLE |
|--------|-----|-------------|-----------------------------------|
| -19 | 1 | C250-C-19 | BUMPER |
| 29 | 1 | MS16555-646 | SS DOWEL PIN 1/4" DIA. X 3/4" LG. |



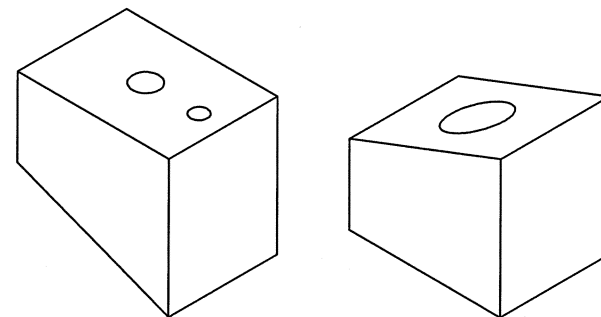
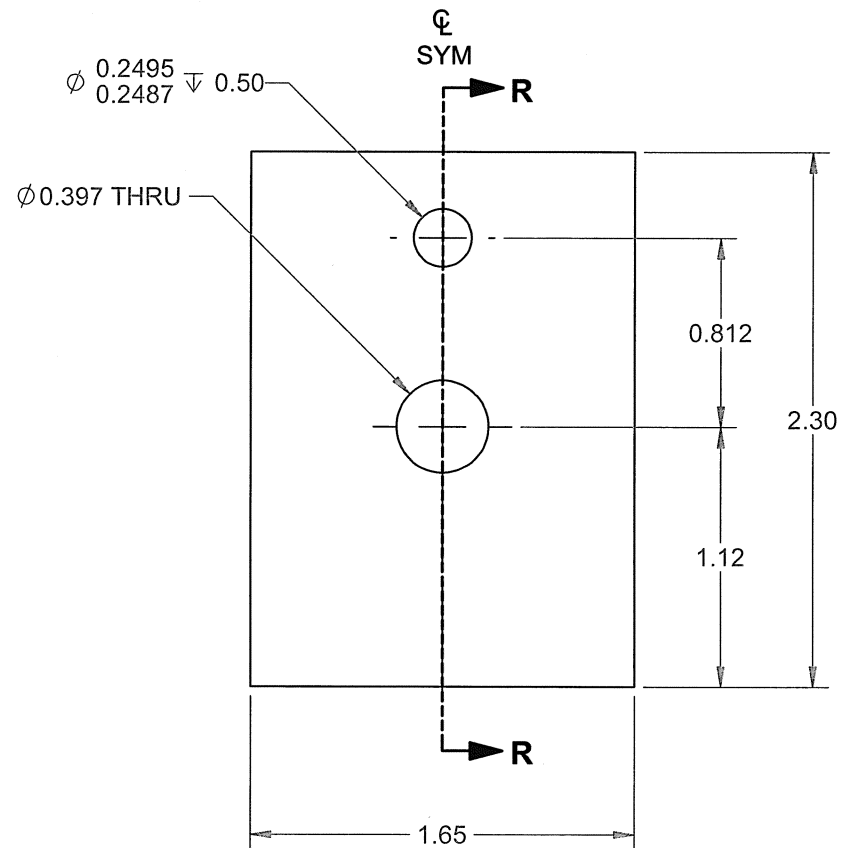
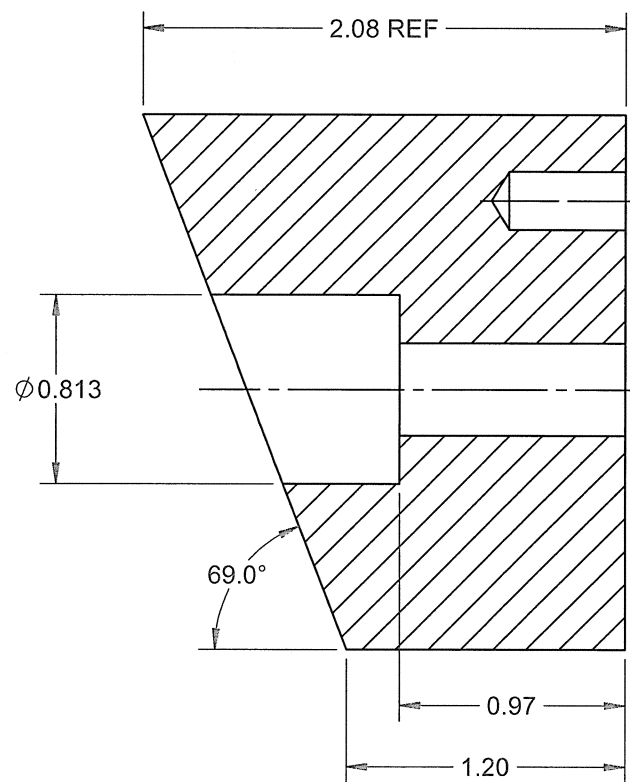
SECTION P-P



C250-C-18 BUMPER ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM 29 WITH ITEM -19, AND REMOVE EXCESS

| | | | |
|------------|------------|---|----------------|
| DESIGN | KPT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | KPT | | |
| CHECKED | ZF | TOOL PART # C250-C | REV. D |
| MFG. APPR. | DP | TITLE C250 CAGE ASSEMBLY | SHEET 21 OF 23 |
| APPROVED | | SCALE NTS | |
| DATE | 2019-10-21 | COPYRIGHT © 2019 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |



- NOTES:
- 1) MATERIAL: UHMW
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

| | | | |
|------------|------------|--|----------------|
| DESIGN | KPT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | KPT | | |
| CHECKED | ZF | TOOL PART # C250-C | REV. D |
| MFG. APPR. | DP | TITLE C250 CAGE ASSEMBLY | SHEET 22 OF 23 |
| APPROVED | | SCALE NTS | |
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6

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4

3

2

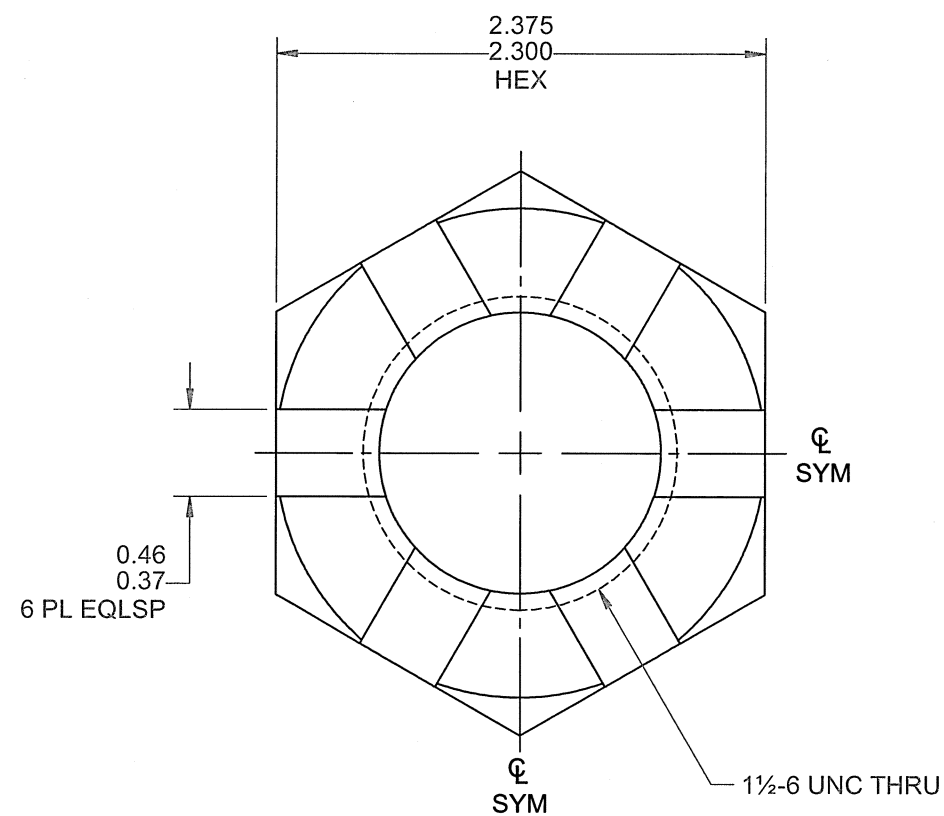
1

D

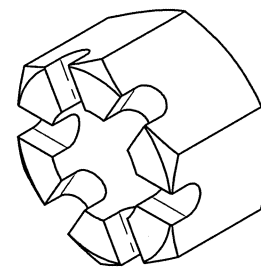
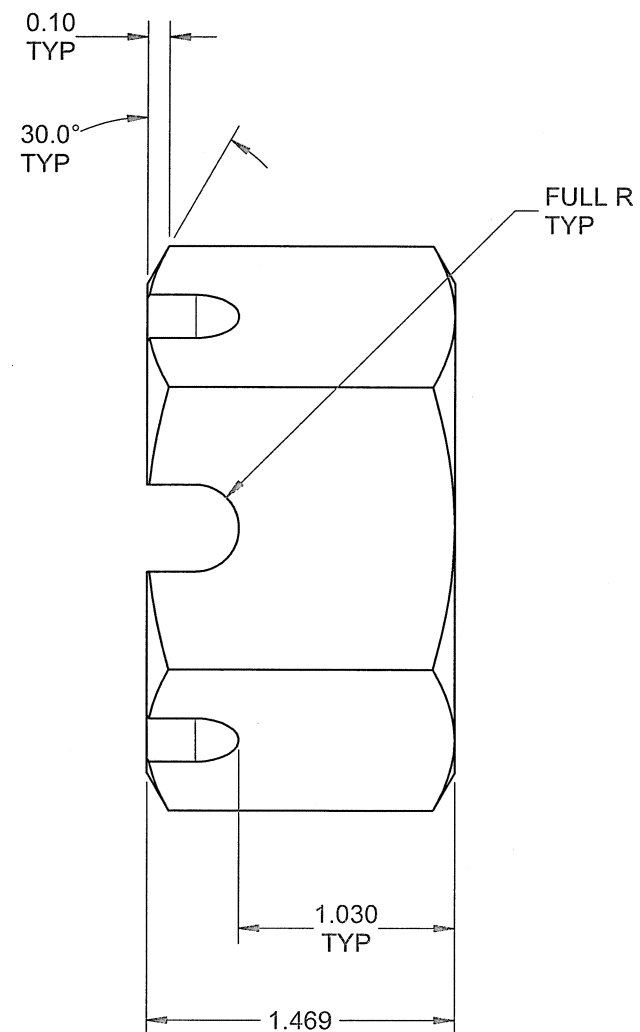
C

B

A

**C250-C-20 LIFTING NUT**

8



D


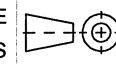
C

B

A

NOTES:

- 1) MATERIAL: SEE NOTE 8
- 2) HEAT TREAT: SEE NOTE 8
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) LIFTING NUT MUST CONFORM TO ASTM A563 (GRADE DH) OR ASTM A194 (GRADE 2H)

| | | | |
|------------|---|---|---|
| DESIGN | KPT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | KPT | | |
| CHECKED | ZF | TOOL PART # C250-C | REV. D |
| MFG. APPR. | DP | TITLE C250 CAGE ASSEMBLY | SHEET 23 OF 23 |
| APPROVED |  | SCALE NTS |  |
| DATE | 2019-10-21 | COPYRIGHT © 2019 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |